

Work Order ID 45457

August 4, 2009 9:48:51 AM



Page 1

Item ID: D130-780-042

Accept



Setup Start



Revision ID: A

Stop



Item Name: SPACEPOD RH

Start Date: 7/15/09 Start Qty: 1.00



Cust Item ID:

Required Date: 8/03/09 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: ☒ Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels per PPP D130-780-042 CHG 001

S 09/08/06

105

0.00



Small Fab

Memo

0.00

Small Fab

106

QCS- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> S 09/08/05



Work Order ID 45457

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Page 2

Item ID: D130-780-042

Accept



Setup Start



Revision ID: A

Item Name: SPACEPOD RH

Stop



Start Date: 7/15/09 Start Qty: 1.00



Cust Item ID:

Required Date: 8/03/09 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

107	Wing Walk as per dwg QSI005 4.4 Batch	0.00							
-----	---------------------------------------	------	--	--	--	--	--	--	--

Bl 04-08-5 ①



HandFinish

Memo

0.00

Hand Finishing

126	Packaging	0.00							
-----	-----------	------	--	--	--	--	--	--	--

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D130-780-042 □ Location: _____ □ PPP Rev: *A*

9/8/6 ① 84

126	Pick Kit	0.00							
-----	----------	------	--	--	--	--	--	--	--

Packaging

Memo

0.00

Packaging

9/8/6 sf

Work Order ID 45457

August 4, 2009 9:48:51 AM



Page 3

Item ID: D130-780-042

Accept



Setup Start



Revision ID: A

Stop



Item Name: SPACEPOD RH

Start Date: 7/15/09 Start Qty: 1.00



Cust Item ID:

Required Date: 8/03/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

126

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

⇒ 8/28/09

(41)

PS

Polled auto
52768
D130-780-042

MF 09-08-24

Picklist Print

June 29, 2009 1:05:09 PM

Page 1

Work Order ID: 45457

Parent Item: D130-780-042RevA

Parent Item Name: SPACEPOD RH

Comments:

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
3235-020-935 Washer - Countersunk A3235-020-935		Purchased	No	M106150			Each	815.0000	1.0000	8.0000 9/8/5		
Washer - Countersunk AKS4-1032-130		Purchased	λ No				Each	815.0000	8.0000			M106150 SP
AKS4-1032-130 Inserts AKS4-1032-130		Purchased	x No				Each	1.0000	28.0000			110511 SP
AKS4-1032-130 Inserts AN3-10A		Purchased	No	110511 SP			Each	1.0000	10.0000			
AN3-10A Bolt AN3-3A		Purchased	No	17566 SP			Each	127.0000	2.0000			
AN3-3A Bolt AN3-6A		Purchased	No	111925 SP			Each	229.0000	4.0000			
AN3-6A Bolt AN525-10R7		Purchased	No	112082 SP			Each	138.0000	4.0000			
AN525-10R7 Screw AN526-832R24		Purchased	No	112314 SP			Each	268.0000	38.0000			
AN526-832R24 Screw		Purchased	No	See ATTACHED			Each	213.0000	4.0000			?

Picklist Print

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Page 2

Work Order ID: 45457

Parent Item: D130-780-042RevA

Parent Item Name: SPACEPOD RH

Comments:

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
S ✓ AN526C832R14		Purchased	No		104916	SP	Each	1,051.000	8.0000			
Screw												
S ✓ AN5-5A		Purchased	No		110363	SP	Each	116.0000	1.0000			
Bolt												
S ✓ AN960JD10	Q57007 equivalent	Purchased	No		111668	SP	Each	1,246.000	8.0000			
Washer												
AN960JD516		Purchased	No		112082	SP	Each	1,603.000	3.0000			
Washer												
S ✓ D130-780-013RevA		Manufactured	No		45035	SP	Each	5.0000	1.0000			
SWITCH RELOCATION KIT												
S ✓ D130-780-044RevA	instalup	Manufactured	No		1345538	SP	Each	0.0000	1.0000			
SPACEPOD RH												
S ✓ D2237RevD1		Manufactured	No				Each	30.0000	2.0000		46162	
Striker Plate												
S ✓ D3015-3RevB		Manufactured	No		48238	SP	Each	435.0000	1.0000			
Locknut												
S ✓ D3188-2MRevE		Manufactured	No				Each	0.0000	1.0000			
SPACEPOD BODY RH												

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Shop Packet Print

Page 2

Picklist Print

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Page 3

Work Order ID: 45457

Parent Item: D130-780-042RevA

Parent Item Name: SPACEPOD RH

Comments:

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 1.00

Required Qty: 1.00



Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ D3538-1RevA 		Manufactured	No				Each	40.0000	2.0000			
Hinge Bracket ✓ D3547-1RevA 		Manufactured	No		35455 SP		Each	20.0000	1.0000			
Bracket ✓ D3550-1RevB 		Manufactured	No		36226 SP		Each	31.0000	1.0000			
Strut ✓ D3554-7RevA 		Manufactured	No		37674 SP		Each	81.0000	1.0000			
Ball Stud ✓ D3798-042RevA 		Manufactured	No		45579 SP		Each	2.0000	1.0000			
Spacepod Floor ✓ D3815-041RevA 		Manufactured	No		45729 SP		Each	17.0000	2.0000			
Web Assembly ✓ D3837-1RevB 		Manufactured	No		46231 SP		Each	12.0000	1.0000			
Decal ✓ D3837-4RevB 		Manufactured	No				Each	11.0000	1.0000			
Decal ✓ MS20426AD4-5 		Purchased	No		4067 SP 9/8/5		Each	7,958.000	4.0000			
Rivet												

46753 SP

37674 SP

46233 SP

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Shop Packet Print

Page 3

Picklist Print

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Page 4

Work Order ID: 45457

Parent Item: D130-780-042RevA

Parent Item Name: SPACEPOD RH

Comments:

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ MS21042L3		Purchased	No		111274 SP		Each	1,873.000	16.0000			
Nut												
✓ MS21042L5		Purchased	No		111127 SP		Each	791.0000	1.0000			
Nut												
✓ MS21042L8		Purchased	No		112243 SP		Each	41.0000	4.0000			
Nut												
✓ MS24694-S67		Purchased	No		③ 104537 111965 ①		Each	167.0000	7.0000			
Screw												
✓ MS24694-S69		Purchased	No		103574 SP		Each	27.0000	1.0000			
Screw												
✓ NAS1149D0332J		Purchased	No		110844		Each	271.0000	16.0000			
Washer					91515 SP							
✓ NAS1149DN832J		Purchased	No				Each	107.0000	4.0000			
WASHER												

91730 SP

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Shop Packet Print

Page 4

x MS21042808

AN 960508

AN 526 C 832 R 10

AN 526 C 832 R 12

AN 96050516

MS 27039-1-15

AN 9605010

MS 21042L3

x 14 nut

M 112243

x 16 washer

M 111578

screw

M 104603

screw

M 107285

washer

M 111279

screw

M 111916

washer

M 111668

nut

M 111274

page 5

Spaced LH B47001B

MS 27039-0811 x 2

screw

M 106335

washer

M 110379

large bracket

B 35432

screw

M 104603

MS 20426AD4-4

nut

15511

25

IT 10-08-19

x 2179

MS 1515H3

x 2

washer

M 110379

large bracket

B 35432

screw

M 104603

x AN 526 C 832 R 24 x 4

nut

15511

25

IT 10-08-19

2586 / 47185 ax
2585 / 45888 2x
2228 / 48228
3557-1 / 32447
2857-2 / 43363
2857-1 / 45788
21891 / 46842 2x

Date: Wednesday, 25/03/2009 10:53:58 AM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SPACEPOD RH, EC 130 B4
Job Number :	45457		
Estimate Number :	13762		
P.O. Number :		Part Number :	D130780042
This Issue :	25/03/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	IIN-D130-780
First Issue :	03/02/2009	Project Number :	N/A
Previous Run :	45455	Drawing Revision :	A
		Material :	
Written By :		Due Date :	15/03/2009
Checked & Approved By :	JUL 09.03.25		
Comment :	Est Rev:A 09-02-03 new issue DD verified by:JLM		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

✓ DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels per PPP D130-780-042 CHG 001

2.0

✓ D130780044

Spacepod Door Assembly, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Spacepod Door Assembly, RH

batch: _____

3.0

✓ D130780013

Switch Relocation



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Switch Relocation

batch: _____

4.0

✓ D31882M

SPACEPOD BODY RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SPACEPOD BODY RH

batch: _____

5.0

✓ AKS71032130

Insert



Comment: Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s)

Insert

batch: 110511

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval. QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 25/03/2009 10:53:58 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD RH, EC 130 B4

Job Number: 45457

Part Number: D130780042

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0



D38374

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Decal

batch:

7.0



D2237

Striker Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Striker Plate

batch: 46162

8.0



MS20426AD45 -

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Rivet

batch: 4067

9.0



D35381

Hinge Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Hinge Bracket

batch: 46753

10.0



AN526C832R24

screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

screw

batch:

11.0



NAS1149DN832J

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch:

12.0

MS21042L08

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

batch:

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval. QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 25/03/2009 10:53:58 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD RH, EC 130 B4

Job Number: 45457

Part Number: D130780042

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

-Assemble as per dwg D3188,
-use door to transfer drill hole location.
-Install inserts

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk Spacepod top surface of Pod as per Dwg D3188 & QSI 005 4.4
Batch: _____

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

18.0

D3815041

Web Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Web Assembly

batch: _____

19.0

D38371

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Decal

batch: _____

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval. QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 25/03/2009 10:53:58 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD RH, EC 130 B4

Job Number: 45457

Part Number: D130780042

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

✓ D30153

Locknut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Locknut

batch: _____

21.0

✓ D3798042

Spacepod Floor, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Spacepod Floor, RH

batch: _____

22.0

✓ D35471

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket

batch: _____

23.0

✓ D35501

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Strut

batch: _____

24.0

✓ D35547

Ball Stud



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Ball Stud

batch: _____

25.0

✓ AN33A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

batch: _____

26.0

✓ AN36A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

batch: _____

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval. QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 25/03/2009 10:53:58 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD RH, EC 130 B4

Job Number: 45457

Part Number: D130780042

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0



AN310A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: _____

28.0



AN55A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

batch: _____

29.0



AN52510R7

Screw



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Screw

batch: _____

30.0



AN526C832R14

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Screw

batch: _____

31.0



MS24694S67

Screw



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Screw

batch: _____

32.0



MS24694S69

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Screw

batch: _____

33.0



A3235020935

Washer - Countersunk



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer - Countersunk

batch: _____

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval. QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 25/03/2009 10:53:59 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD RH, EC 130 B4

Job Number: 45457

Part Number: D130780042

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

NAS1149D0363J

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

batch: _____

35.0



NAS1149D0332J

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Washer

batch: _____

36.0

NAS1149D0563J

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Washer

batch: _____

37.0



MS21042L3

Nut



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Nut

batch: _____

38.0



MS21042L5

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Nut

batch: _____

39.0



AKS71032130

Insert



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

ALS7-1032-130

batch: _____

(AKS7-1032-130)

40.0



QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 25/03/2009 10:53:59 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD RH, EC 130 B4

Job Number: 45457

Part Number: D130780042

Job Number:



Seq. #:

Machine Or Operation:

Description :

41.0

✓ PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D130-780-042

Location: _____

PPP Rev: _____

42.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

✓



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.0 PARTS LIST

-041	-042	-043	-044	-011	-013	Part Number	Description
X						D130-780-041	SPACEPOD™ LH, EC 130 B4
	X					D130-780-042	SPACEPOD™ RH, EC 130 B4
1		X				D130-780-043	DOOR ASSEMBLY, LH
	1		X			D130-780-044	DOOR ASSEMBLY, RH
1				X		D130-780-011	AFT LH DOOR HINGE KIT
1	1				X	D130-780-013	SWITCH RELOCATION KIT
2	2					D3815-041	WEB ASSEMBLY
						D2464-0360	NEOPRENE SEAL
		1	1			D2589	KEYS, KEY CHAIN
1	1					D3837-1	DECAL
1	1					D3015-3	LOCK NUT
		1				D3186-3	SPACEPOD™ DOOR, LH
			1			D3186-4	SPACEPOD™ DOOR, RH
1						D3798-041	FLOOR
	1					D3798-042	FLOOR
1						D3188-5	SPACEPOD™ BODY
	1					D3188-6	SPACEPOD™ BODY
1	1					D3547-1	BRACKET
1	1					D3550-1	STRUT
		1	1			D3552-7	GAS SPRING
1	1					D3554-7	BALL STUD
4	4					AN3-3A	BOLT
4	4					AN3-6A	BOLT
2	2					AN3-10A	BOLT
1	1					AN5-5A	BOLT
38	38					AN525-10R7	SCREW
8	8					AN526C832R14	SCREW
7	7					MS24694S67	SCREW
1	1					MS24694S69	SCREW
		2	2			MS27039-0811	SCREW
8	8					A3235-020-935	WASHER
8	8					NAS1149D0363J	WASHER
16	16					NAS1149D0332J	WASHER
		4	4			NAS1149DN832J	WASHER
3	3					NAS1149D0563J	WASHER
		2	2			NAS1515H3	NYLON WASHER
		2	2			MS21042L08	NUT
16	16					MS21042L3	NUT (or MS21042-3)
1	1					MS21042L5	NUT
10	10					AKS7-1032-130	INSERT
28**	28**					AKS7-1032-130	INSERT
					2	D3819-1	MALE SPADE CONNECTOR
					2	D3597-1	FEMALE SPADE CONNECTOR

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Revision: A
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NOTICE

ORDER

-041	-042	-043	-044	-011	-013	Part Number	Description
					1	D3598-2-096	EXPANDABLE SLEEVE
					24	D3599-1	TIE-WRAP
					24	D3600-1	TIE-WRAP MOUNT
					24 FT	M22759/41-22-9	WIRE
		1*	1*			D2464-1250	NEOPRENE SEAL
1**		1*				D3837-3	DECAL
	1**		1*	X		D3837-4	DECAL
		2*	2*	✓		D2586	LATCH
		2*	2*	✓		D2585	MOUNTING CHANNEL
		2*	2*	X		D2621	LATCH PLATE
		2*	2*	✓		MS27039-1-15	SCREW
		2*	2*	✓		NAS1149D0363J	WASHER
		2*	2*	X		MS21042L3	NUT (or MS21042-3)
		1*	1*	X		D2857-1	HINGE BRACKET
		1*	1*	X		D2857-2	HINGE BRACKET
		2*	2*	X		D2228	BACKING PLATE
		8*	8*	X		AN526C832R10	SCREW
		8*	8*			NAS1149DN832J	WASHER
		8*	8*	X		MS21042L08	NUT
		1*	1*	X		D3557-1	BRACKET
		2*	2*	X		D2228	BACKING PLATE
		1*	1*	X		D3554-7	BALL STUD
		1*	1*	X		NAS1149D0563J	WASHER 3/6
		1*	1*	X		D3015-3	LOCK NUT
		2*	2*	X		AN526C832R14	SCREW
		2*	2*	X		AN526C832R10	SCREW
		4*	4*	X		NAS1149DN832J	WASHER
		4*	4*	X		MS21042L08	NUT
2**	2**					D2237	STRIKER PLATE
4**	4**					MS20426AD4-5	RIVET
2**	2**					D3538-1	HINGE BRACKET
2**	2**					D2179	HINGE BRACKET PLATE
4**	4**					AN526C832R24	SCREW
4**	4**					NAS1149DN832J	WASHER
4**	4**					MS21042L08	NUT
				1		D3813-041	HINGE ASSEMBLY, UPPER DOOR
				1		D3813-043	HINGE ASSEMBLY, LOWER DOOR
				2***		D3518-3	ROD END
				2***		NAS509-6	NUT
				1		D3814-1	HINGE, UPPER AIRFRAME
				1		D3814-3	HINGE, LOWER AIRFRAME

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Revision: A NO. 415457
Date: 08.10.07

-041	-042	-043	-044	-011	-013	Part Number	Description
				2		D3816-1	SPACER
				4		D3816-3	SPACER
				1		D3817-041	ANCHOR PLATE
				2		AN3-5A	BOLT
				3		AN3-7A	BOLT
				2		AN310-4	CASTLE NUT
				2		AN4-17	BOLT
				2		AN970-4	WASHER
				5		MS21042L3	NUT
				2		MS24665-212	COTTER PIN
				3		MS24694S46	SCREW
				8		NAS1149D0363J	WASHER
				2		NAS1149D0463J	WASHER
				1		D3552-7	GAS SPRING
				2		D3622-1	BALL STUD
				1		D3820-1	DOOR SUPPORT
				2		MS21042L5	NUT
				2		NAS1149D0563J	WASHER

* Pre-installed on D3186-3/-4 Spacepod™ Door

** Pre-installed on D3188-5/-6 Spacepod™

*** Pre-installed on D3813-041/-043 Hinge Assemblies

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Revision: **A**
 Date: 08.10.07



DESIGN JB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3188	REV. E SHEET 1 OF 11
DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS
A	03.04.03	NEW ISSUE	
B	06.10.06	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	
E	07.04.02	ADD HYSOL/FIBER OPTION ON SHEET 11	

RELEASED

07.04.09 **[Signature]**

GENERAL NOTES:

- 1) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
- 2) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
- 3) MATERIALS:
 - RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
 - FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES
 - FOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

4) MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

- 5) APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4

- 6) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S

- 7) ALL DIMENSIONS ARE IN INCHES

- 8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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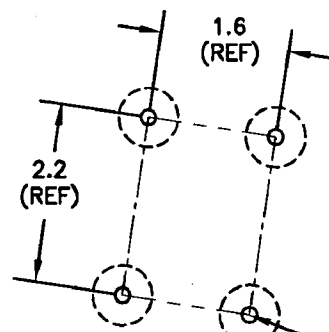
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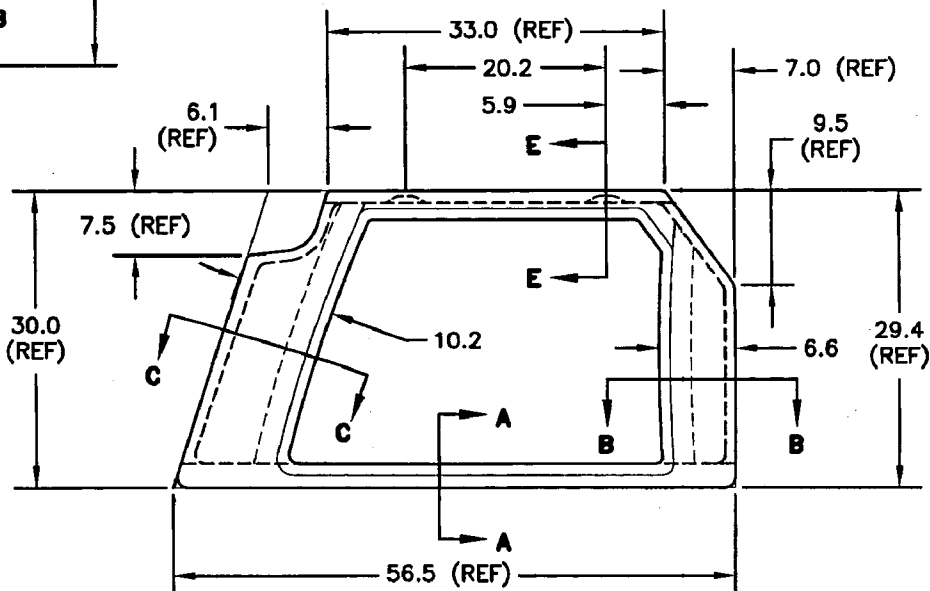
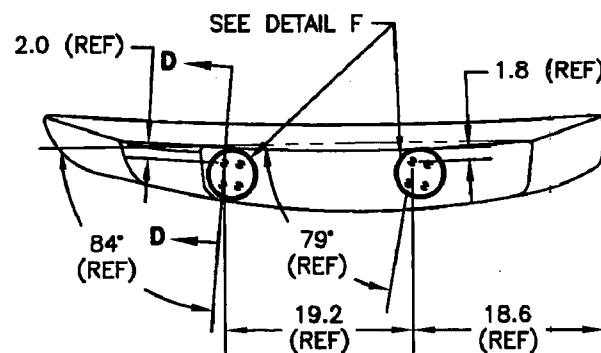
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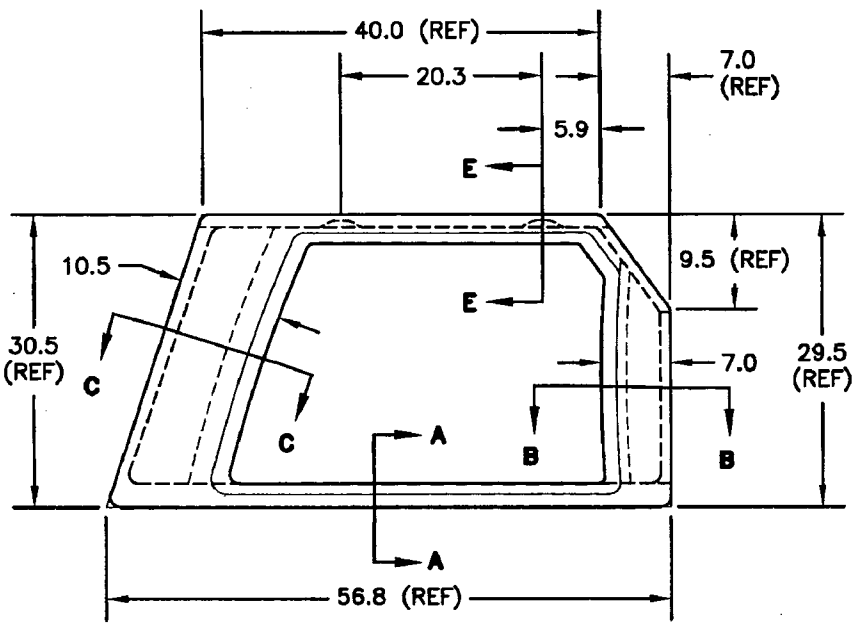
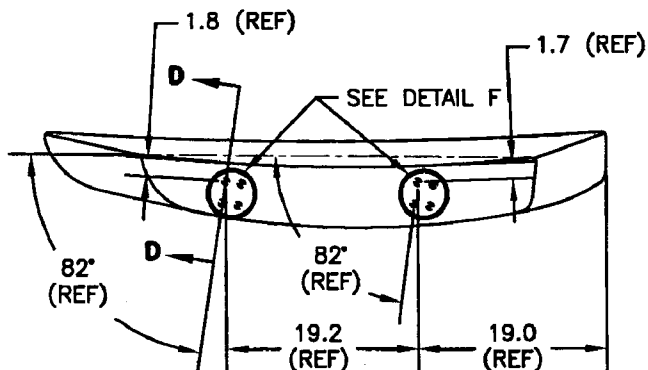
INSTALL
D2213 SPACER
(8 PLACES)
(SEE SECTION D-D)



DETAIL F



D3188-3M SPACEPOD BODY



D3188-1M SPACEPOD BODY

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D3186-1M/-3M NOTES:

- 1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
- 2) SEE SHEET #4 FOR SECTION VIEWS.

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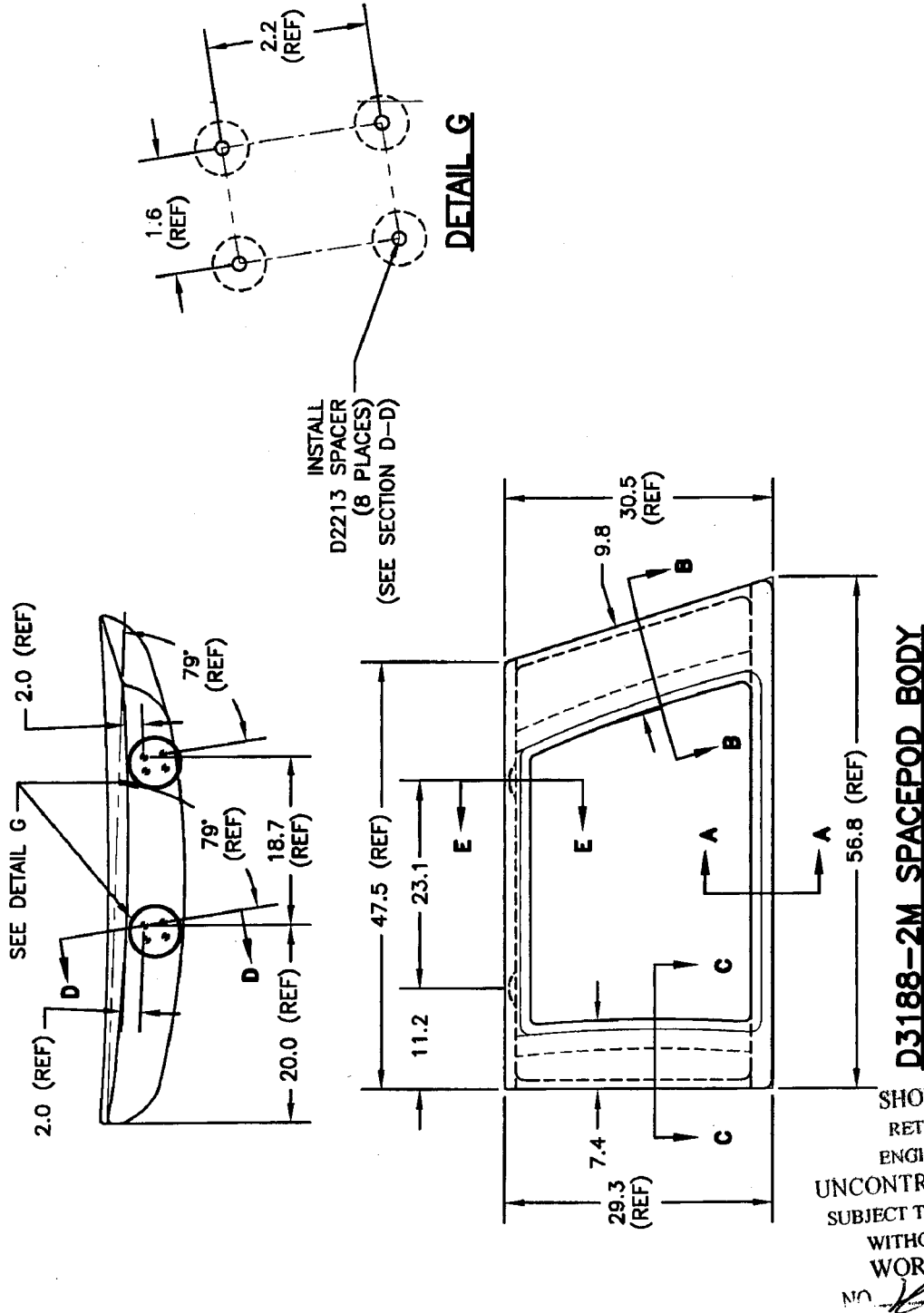
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CHECKED	CE	APPROVED	CB	HAWKESBURY, ONTARIO, CANADA
DATE	07.04.02	TITLE	D3188	REV. E
			SPACEPOD BODY	SHEET 2 OF 11
				SCALE
				NTS



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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

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07.04.01 [Signature]



D3188-2M NOTES:
1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
2) SEE SHEET #4 FOR SECTION VIEWS.

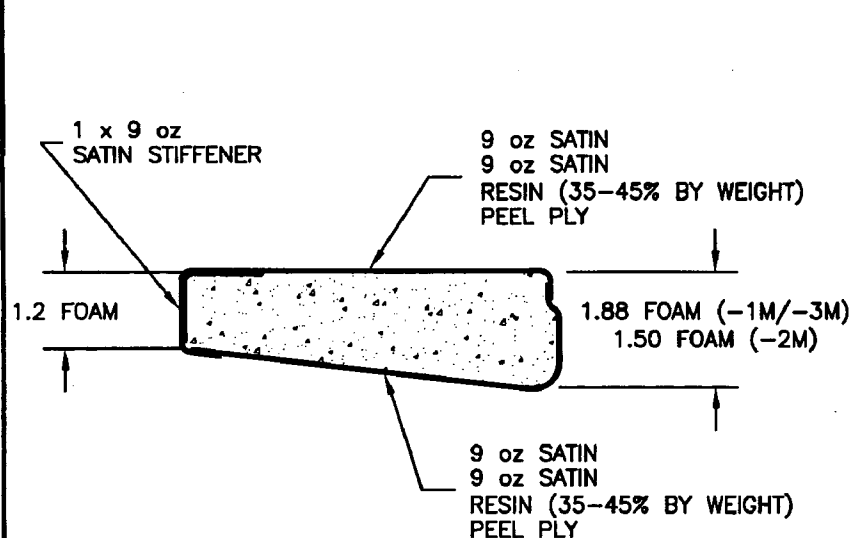
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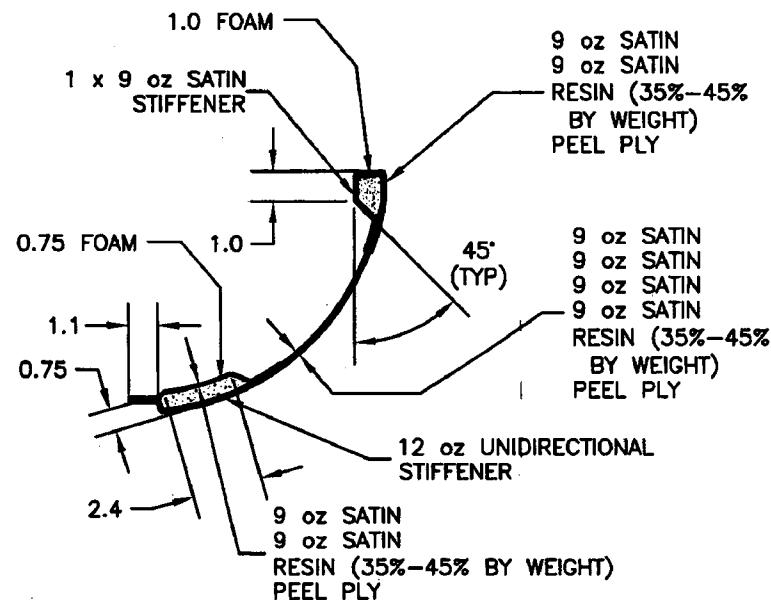


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DATE	07.04.02	TITLE	D3188	REV. E
			SPACEPOD BODY	SHEET 4 OF 11
				SCALE
				NTS

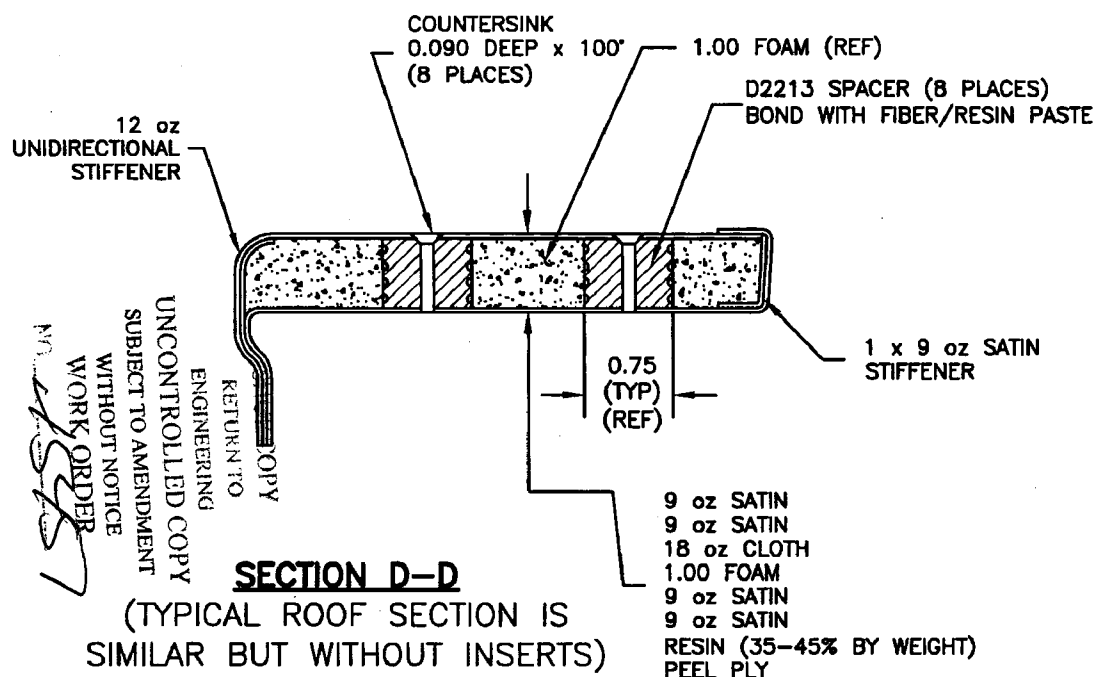
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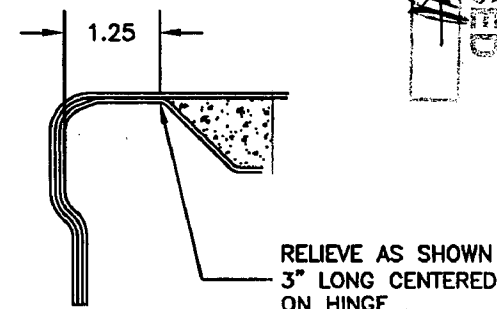
SECTION A-A
(TYPICAL FLOOR SECTION)



SECTION B-B
(SECTION C-C OPPOSITE)



SECTION D-D
(TYPICAL ROOF SECTION IS
SIMILAR BUT WITHOUT INSERTS)



SECTION E-E
(2 PLACES PER POD)

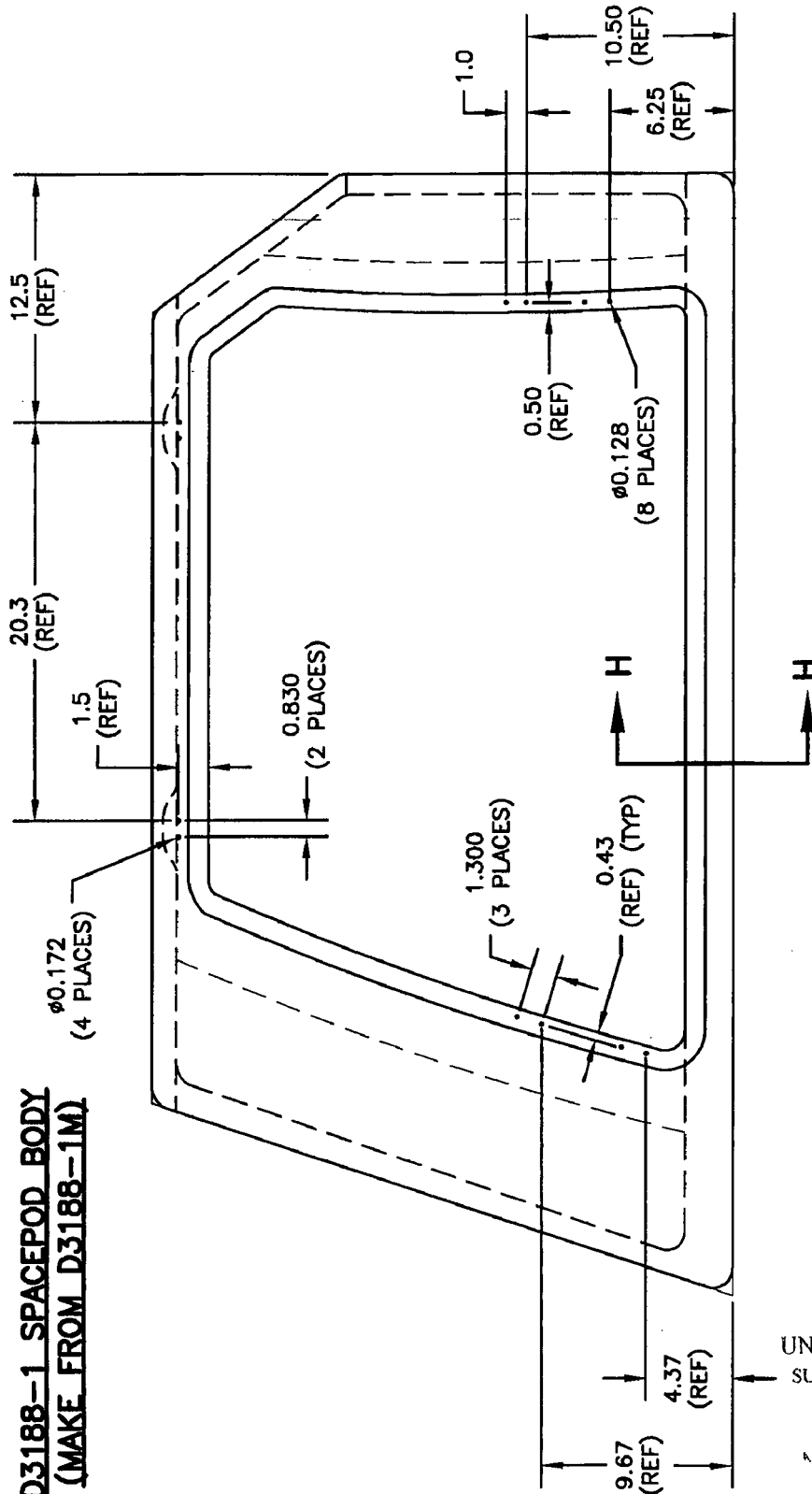
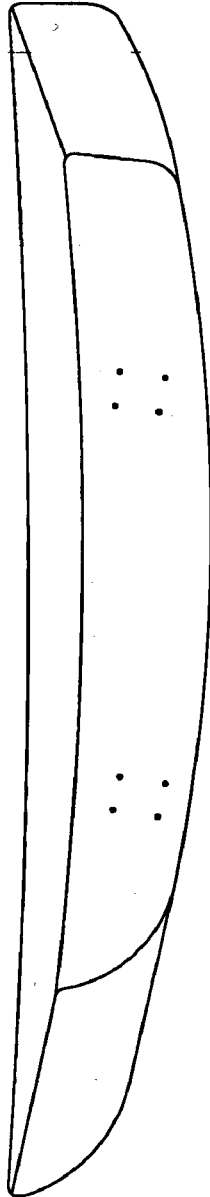
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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

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07.04.02



D3188-1 SPACEPOD BODY
(MAKE FROM D3188-1M)

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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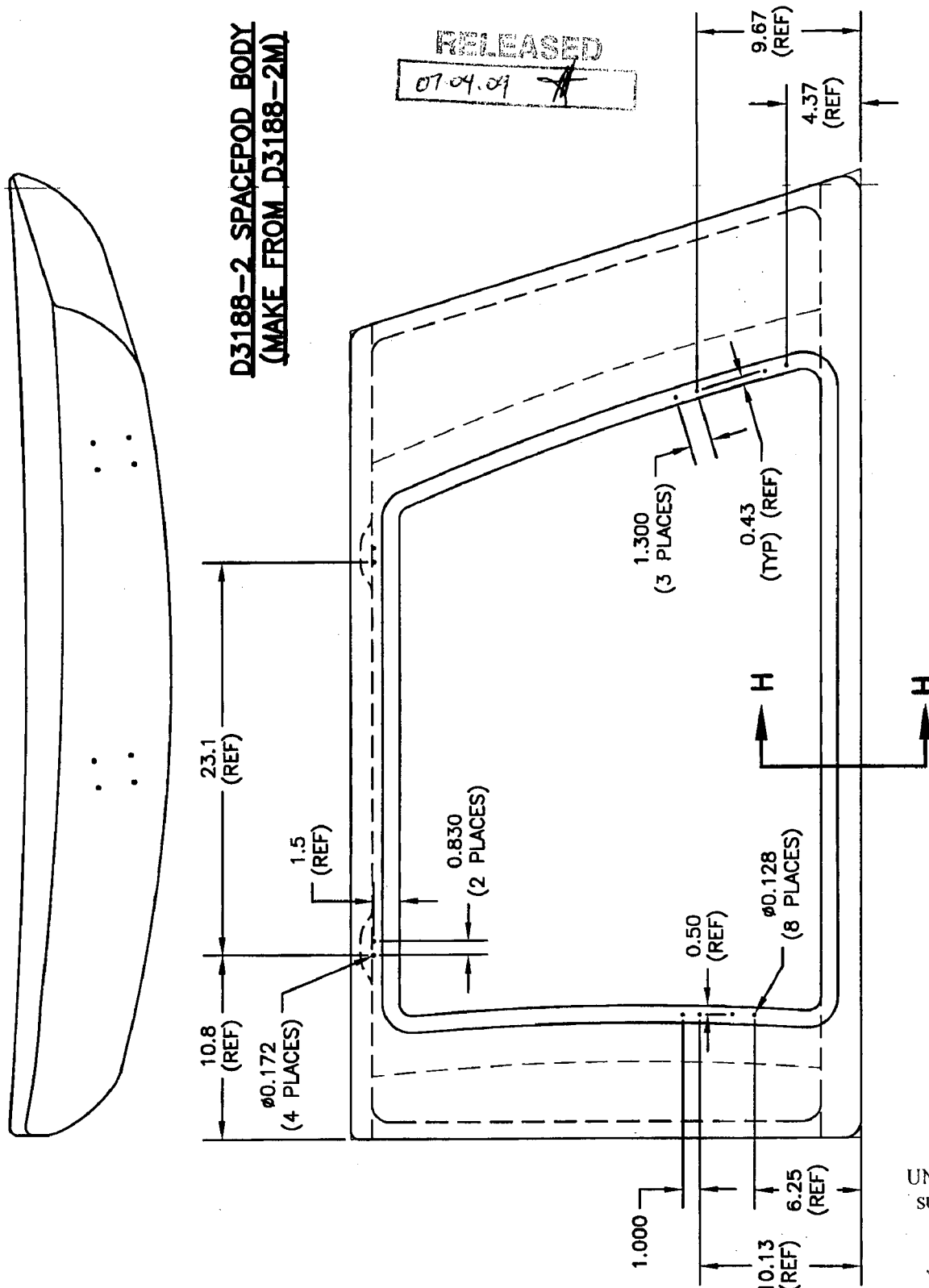
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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

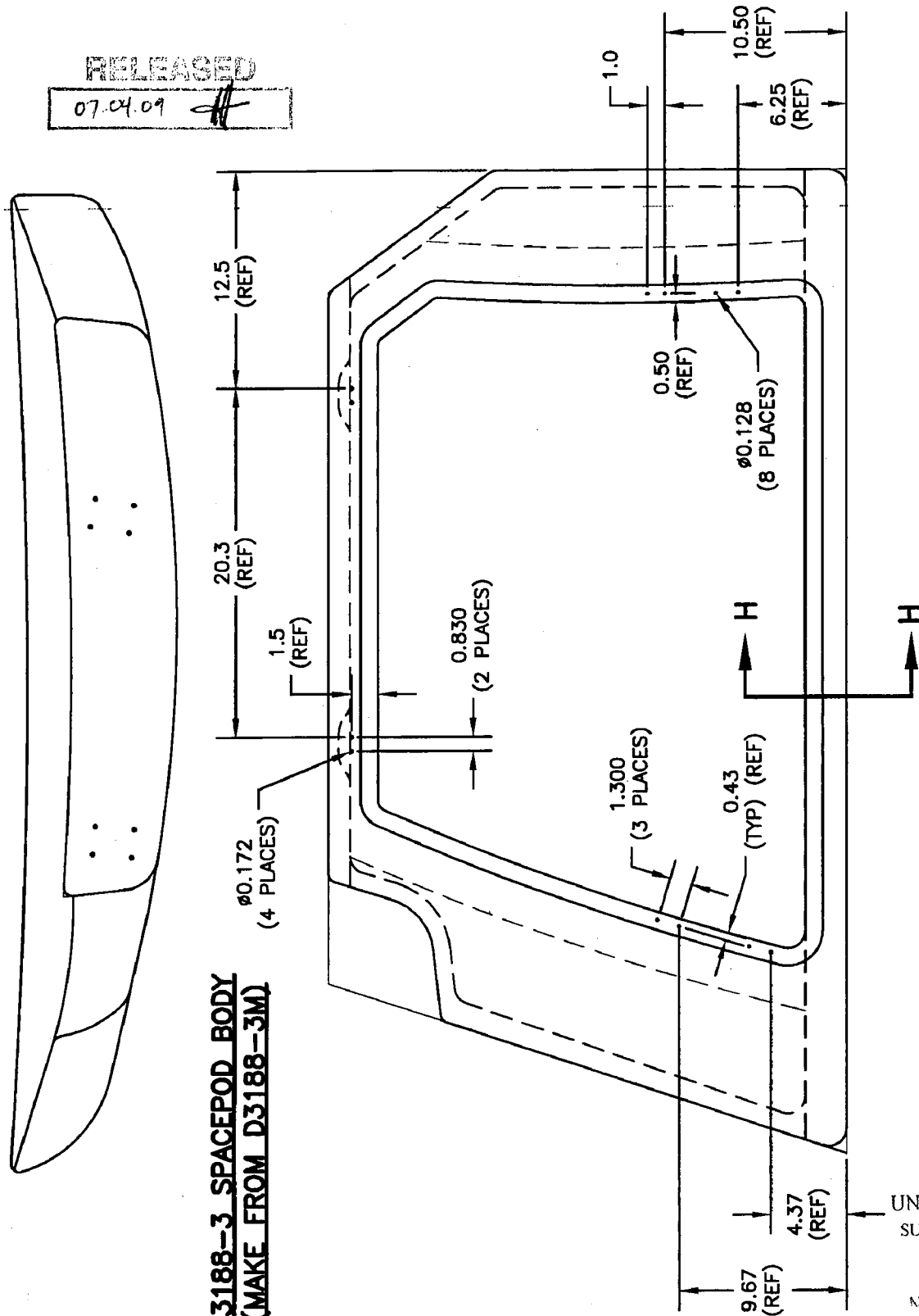
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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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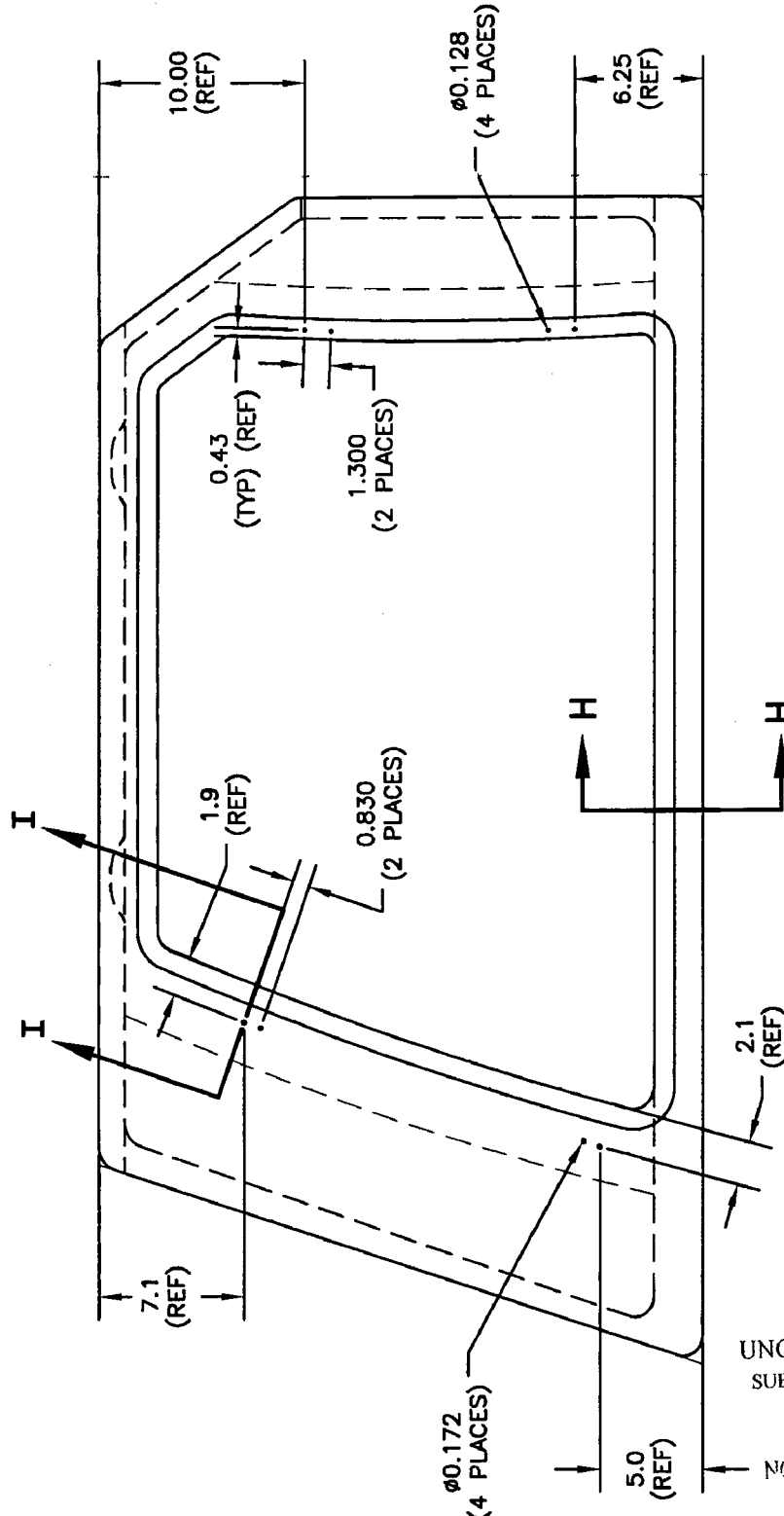
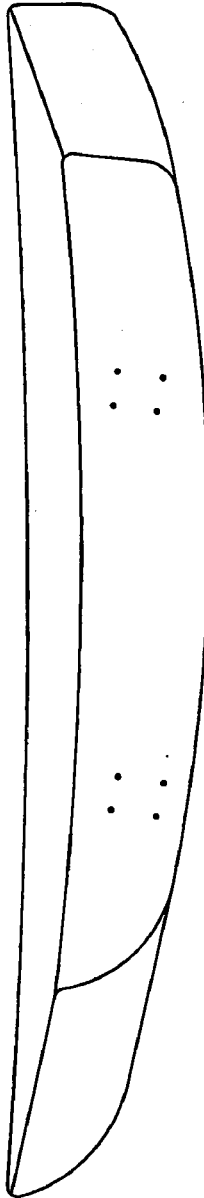
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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

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**D3188-5 SPACEPOD BODY
(MAKE FROM D3188-1M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #111 FOR SECTION VIEWS

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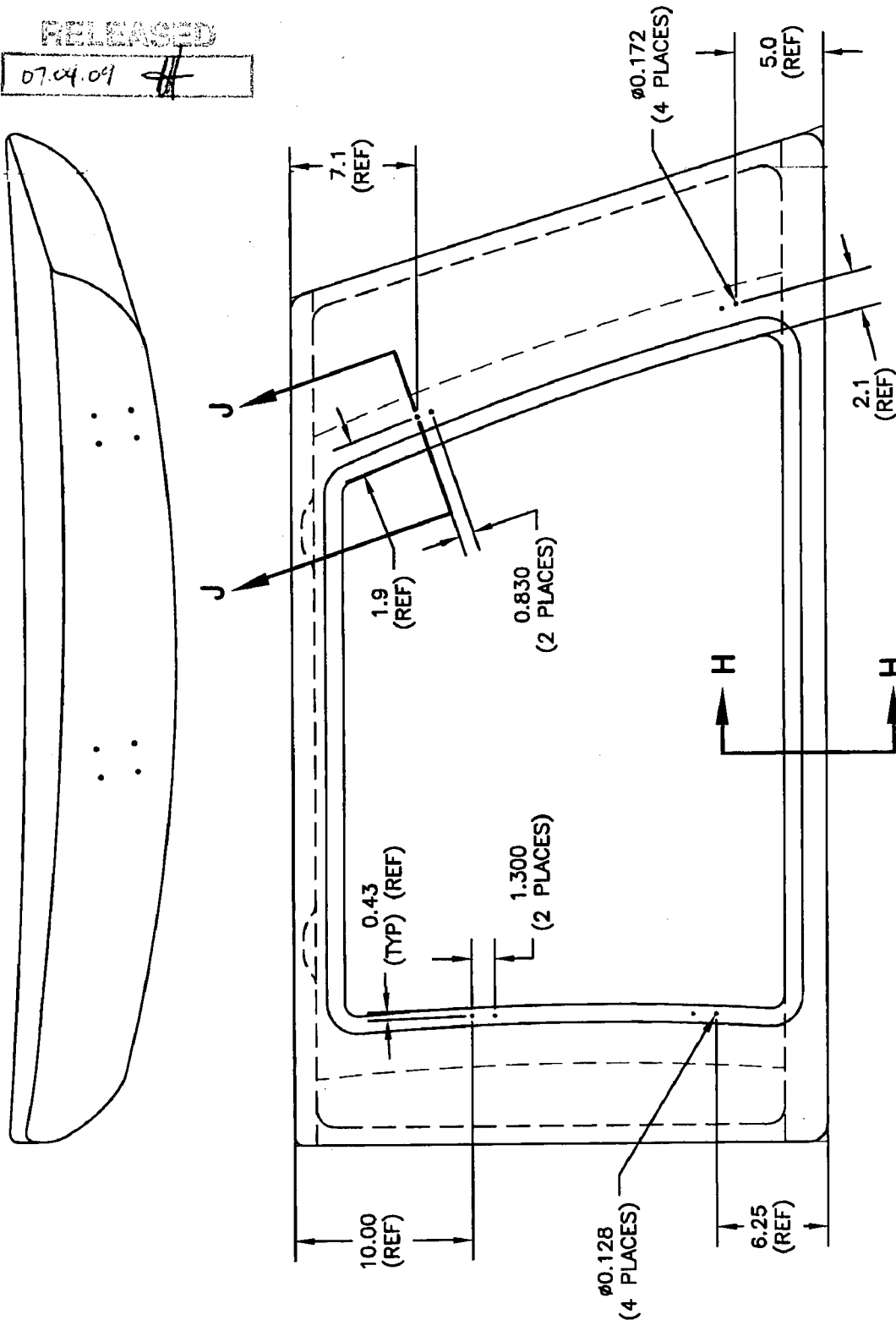
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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

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07.04.09 **#**

**D3188-6 SPACEPOD BODY
(MAKE FROM D3188-2M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
- 2) SEE SHEET #111 FOR SECTION VIEWS
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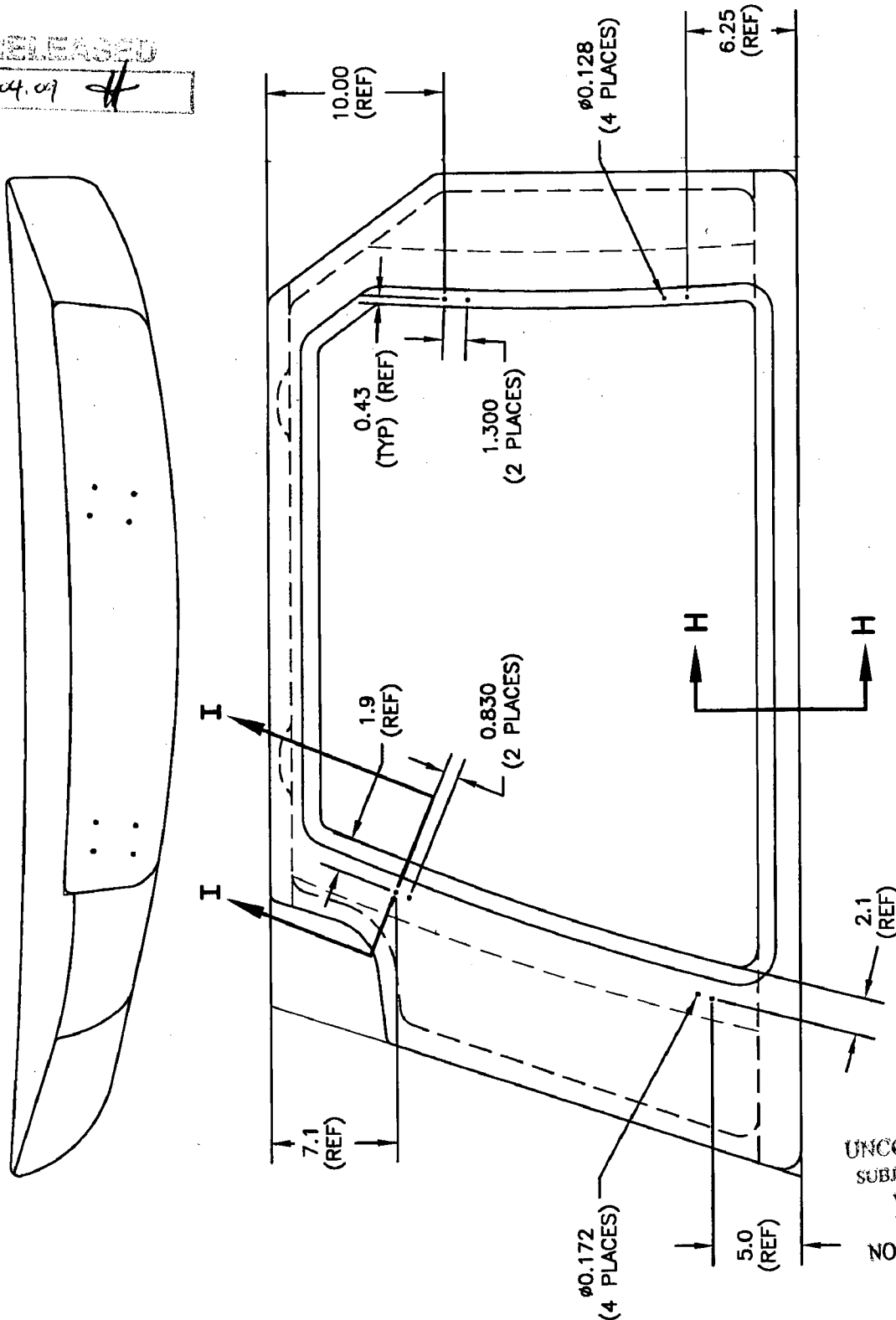
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DATE 07.04.02	TITLE SPACEPOD BODY	SCALE NTS	

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07.04.02 H

**D3188-7 SPACEPOD BODY
(MAKE FROM D3188-3M)**

**NOTE:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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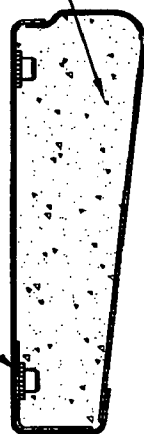
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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

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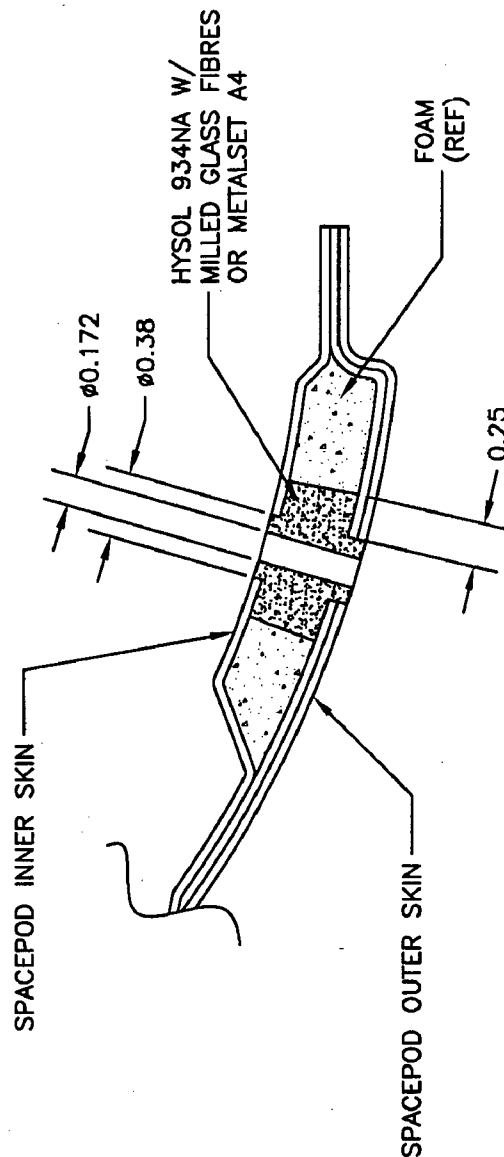
07.04.02

INSTALL AKS7-1032-130
INSERTS (29 PLACES)
PER D3188-1T1 (D3188-1/-3/-5/-7)
OR D3188-2T1 (D3188-2/-6)

FOAM
(REF)



SECTION H-H
(TYPICAL FLOOR SECTION)



SECTION I-I
(SECTION J-J OPPOSITE)
(4 PLACES PER POD)

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DATE	07.04.02	DRAWING NO.	D3188	REV. E
		TITLE	SPACEPOD BODY	SHEET 1 OF 11
		SCALE	NTS	
A	03.04.03	NEW ISSUE		
B	06.10.06	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7		
C	06.12.13	REMOVED D0600-XXX LABELS		
D	07.02.22	UPDATE DIMENSIONS		
E	07.04.02	ADD HYSOL/FIBER OPTION ON SHEET 11		

GENERAL NOTES:

- 1) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
- 2) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
- 3) MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

- 4) MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

- 5) APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
- 6) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S
- 7) ALL DIMENSIONS ARE IN INCHES
- 8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

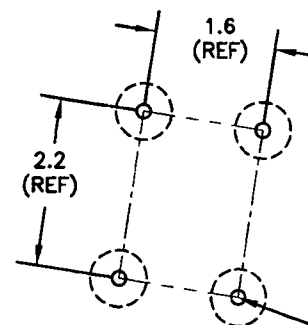
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DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART

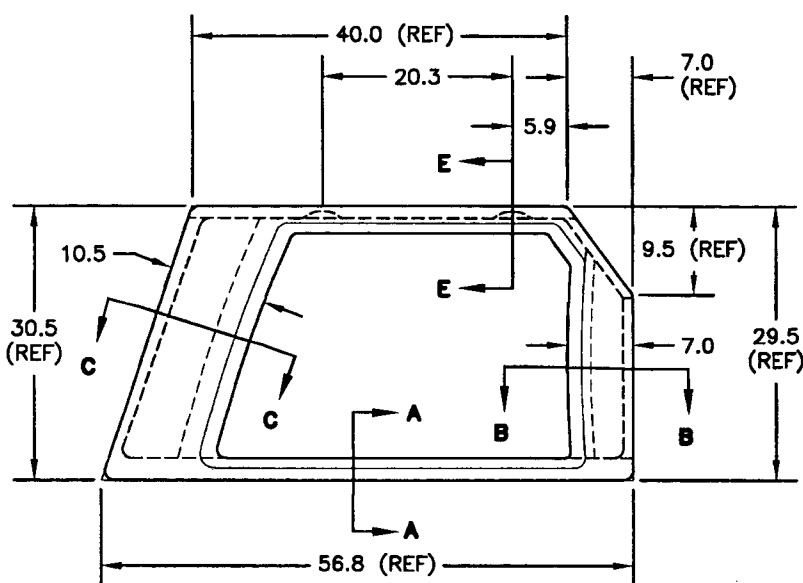
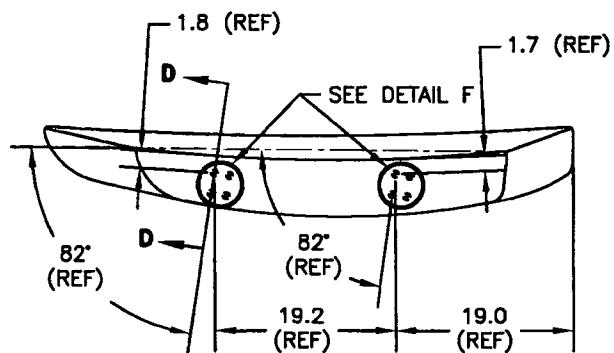
RELEASED
07.04.02

DESIGN JB	DRAWN BY CB	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. E
CHECKED CE	APPROVED CB	DRAWING NO. D3188	SHEET 2 OF 11
DATE 07.04.02	TITLE SPACEPOD BODY	SCALE NTS	

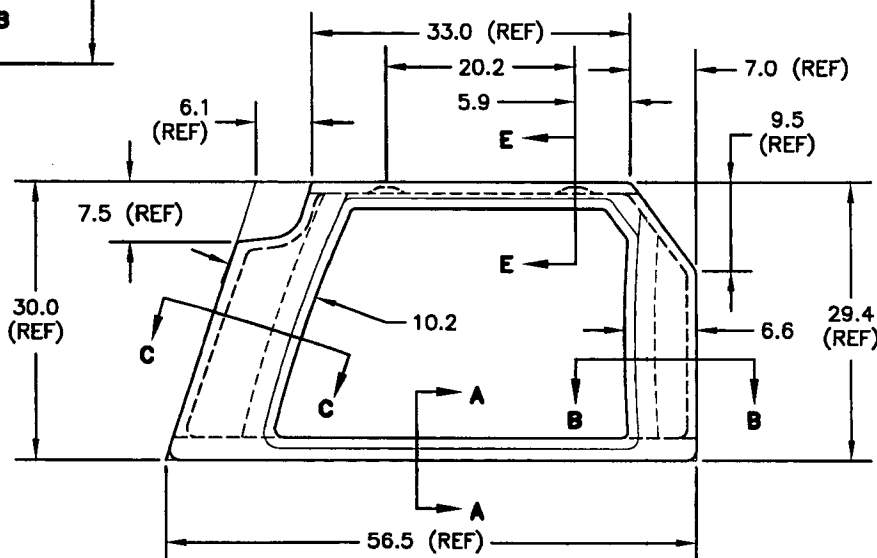
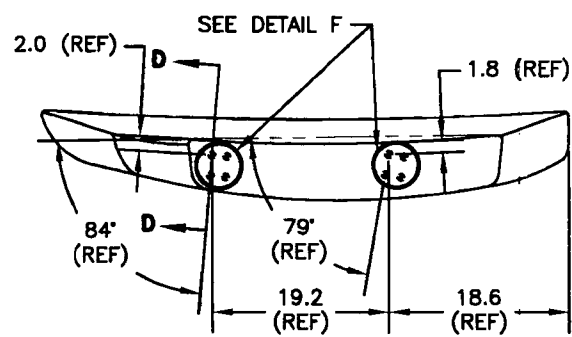


DETAIL F

INSTALL
D2213 SPACER
(8 PLACES)
(SEE SECTION D-D)



D3186-1M SPACEPOD BODY



D3188-3M SPACEPOD BODY

D3186-1M/-3M NOTES:

- 1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
- 2) SEE SHEET #4 FOR SECTION VIEWS.

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DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

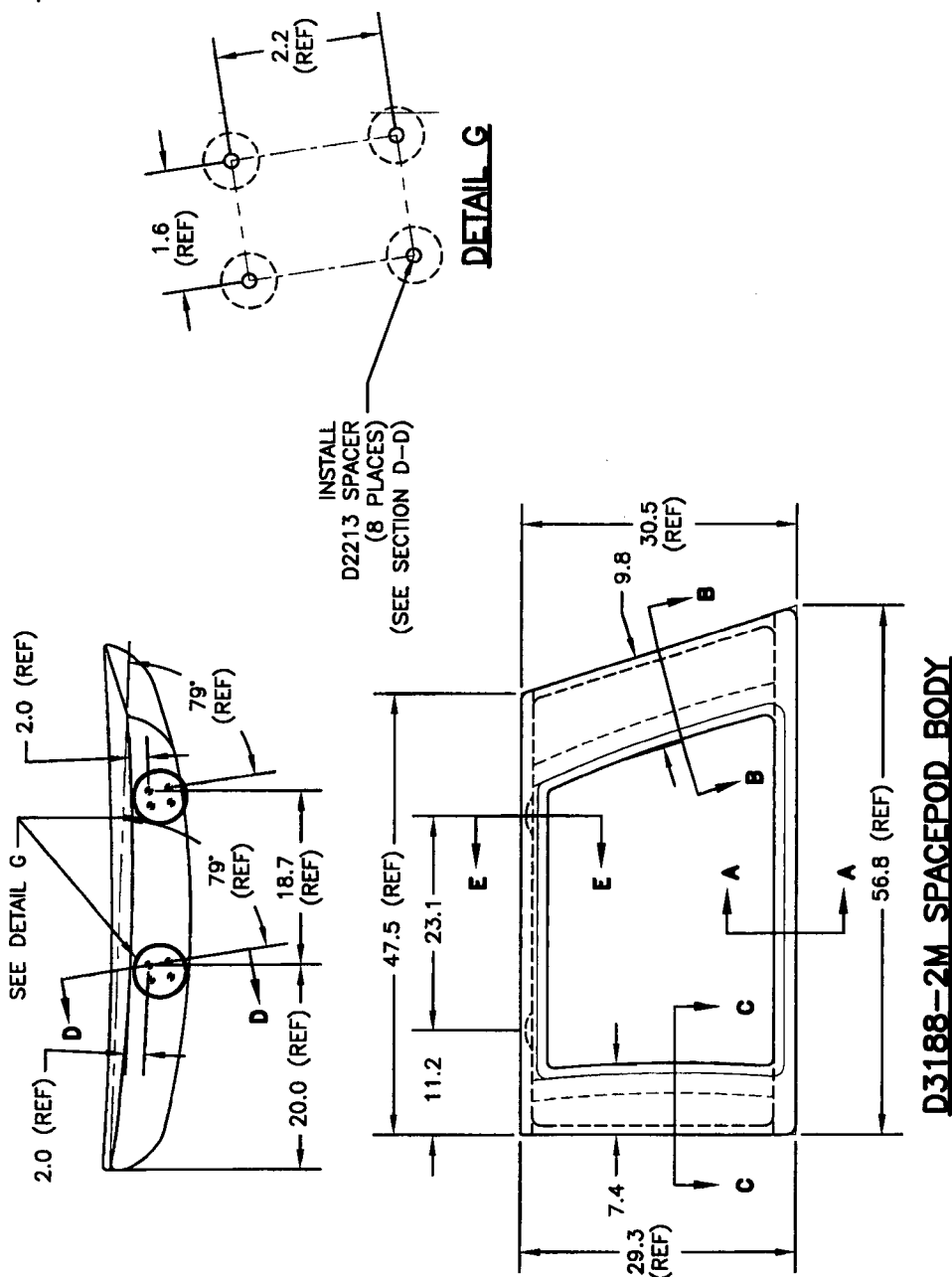
NOTE: Date & initial all entries



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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

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07.04.02 **[Signature]**



D3188-2M NOTES:
1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
2) SEE SHEET #4 FOR SECTION VIEWS.

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DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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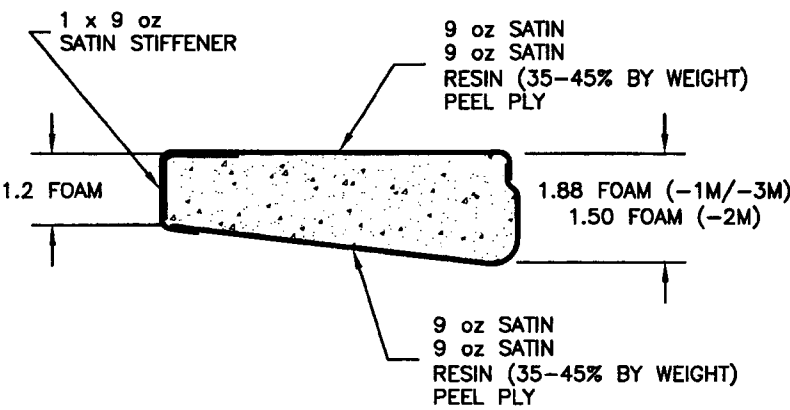
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NOTE: Date & initial all entries

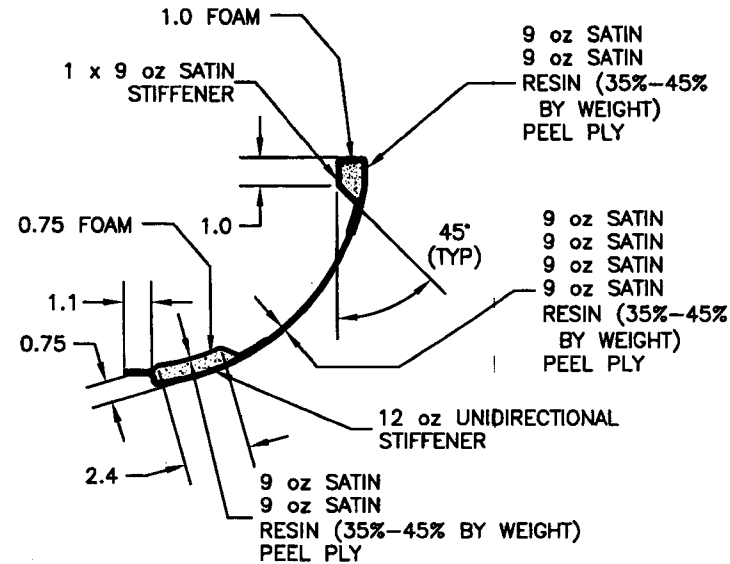
DART

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		TITLE	SPACEPOD BODY	SHEET 4 OF 11
		SCALE	NTS	

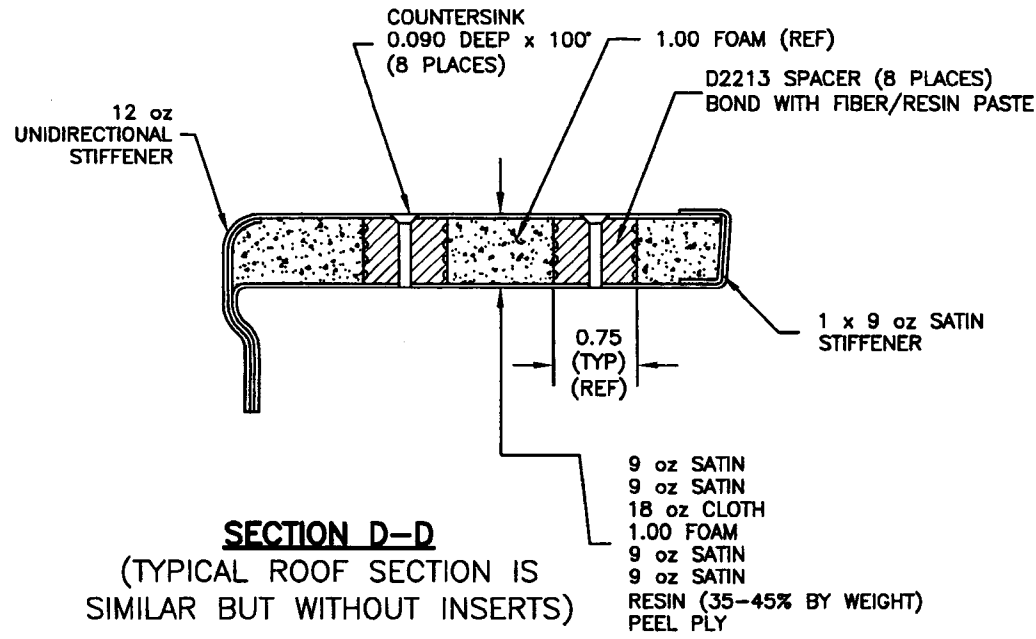
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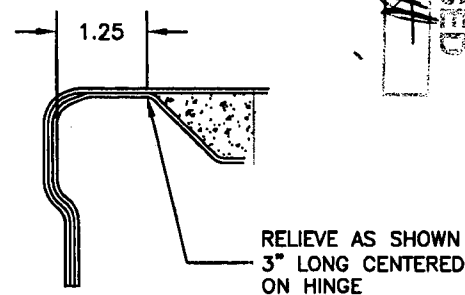
SECTION A-A
(TYPICAL FLOOR SECTION)



SECTION B-B
(SECTION C-C OPPOSITE)



SECTION D-D
(TYPICAL ROOF SECTION IS
SIMILAR BUT WITHOUT INSERTS)



SECTION E-E
(2 PLACES PER POD)

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DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

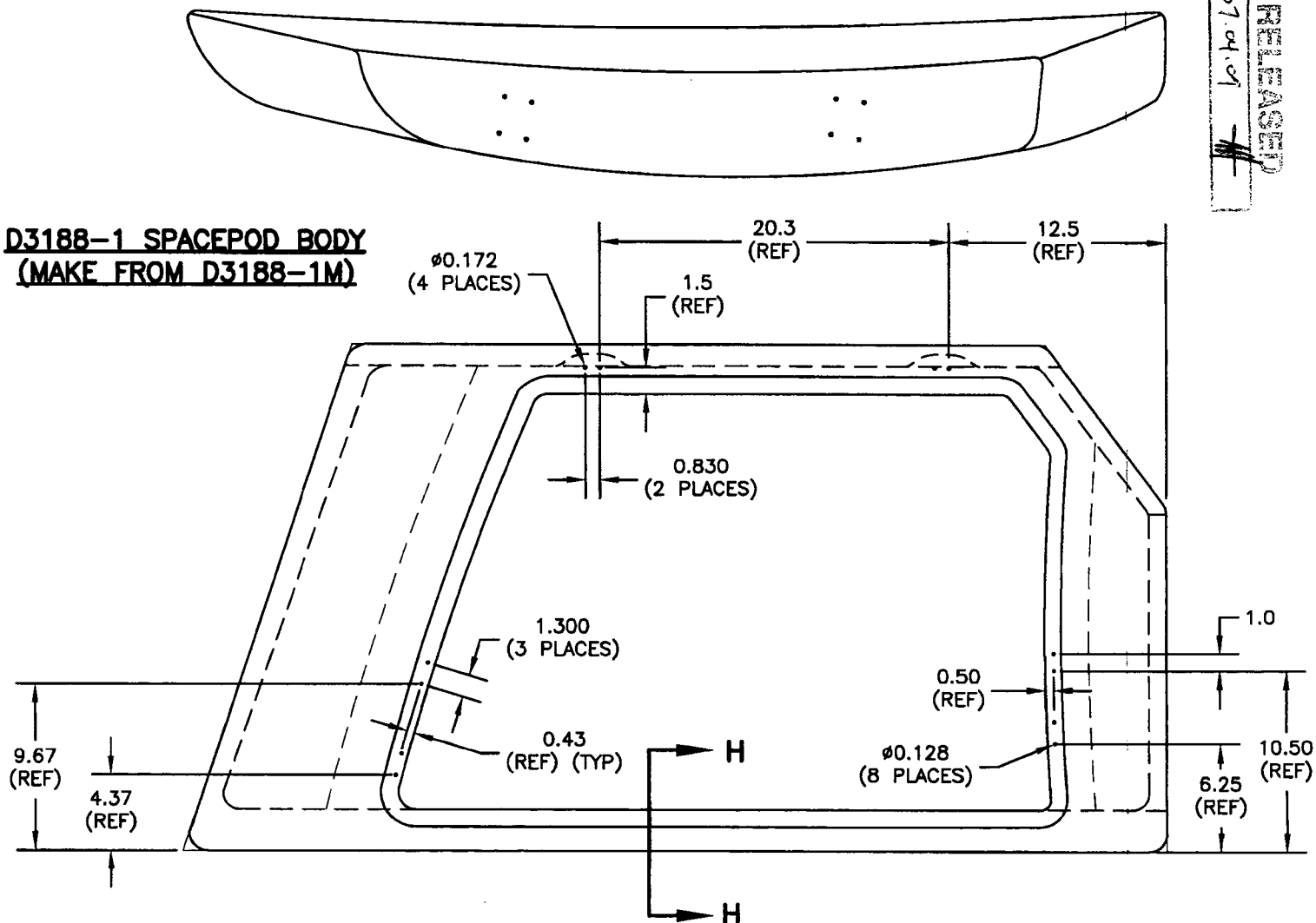
NOTE: Date & initial all entries

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CHECKED	CE	APPROVED	CB	HAWKESBURY, ONTARIO, CANADA	
DATE	07.04.02	DRAWING NO.	D3188	TITLE	SHEET 5 OF 11
				SPACEPOD BODY	SCALE
					NTS

RELEASED

07.04.02



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

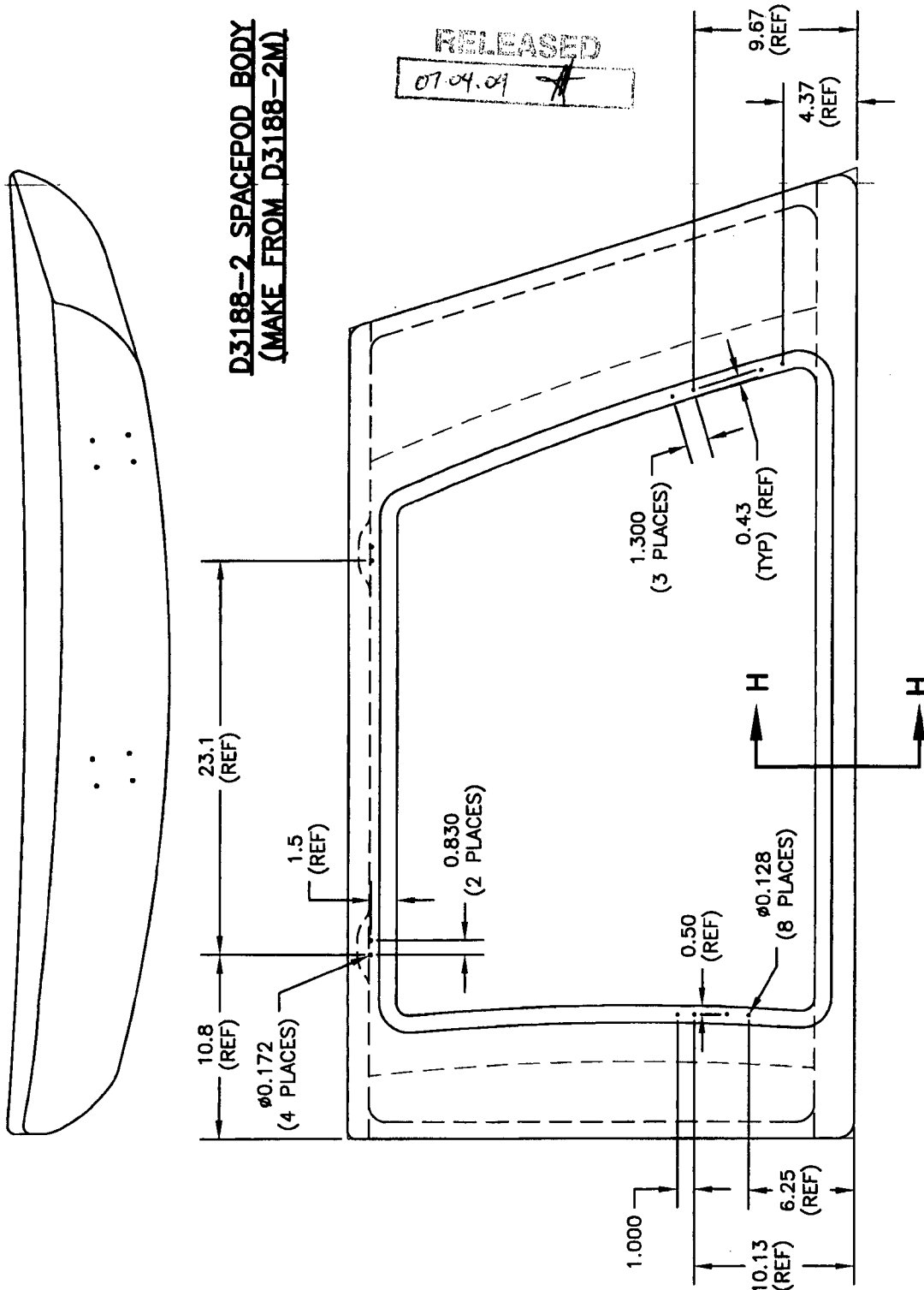
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DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries



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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS



- NOTES:**
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
 - 2) SEE SHEET #111 FOR SECTION VIEW

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DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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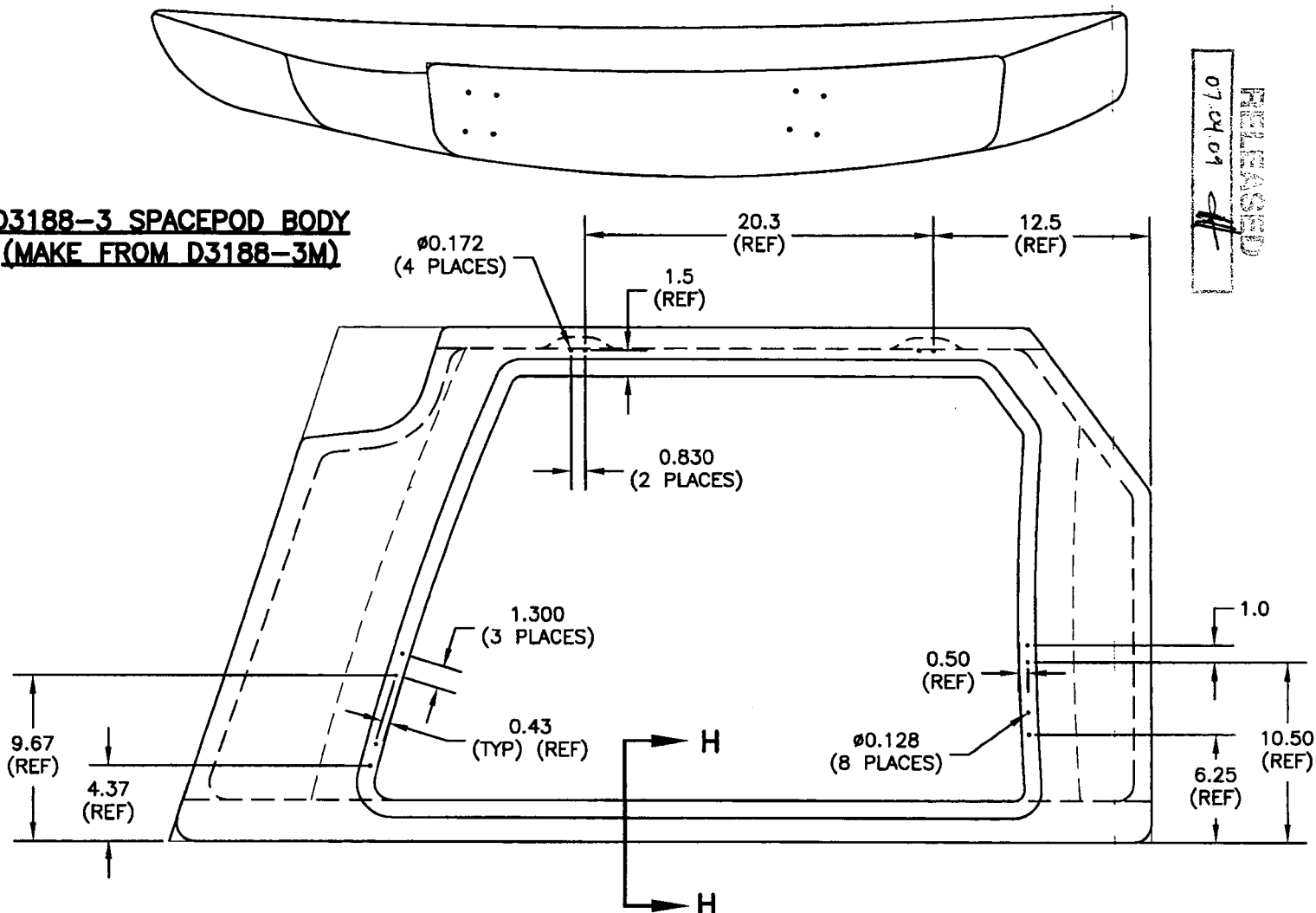
NOTE: Date & initial all entries

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DATE	07.04.02	DRAWING NO.	D3188	REV. E
TITLE	SPACEPOD BODY	SHEET 7 OF 11	SCALE	NTS

RELEASED
07.04.09

D3188-3 SPACEPOD BODY
(MAKE FROM D3188-3M)



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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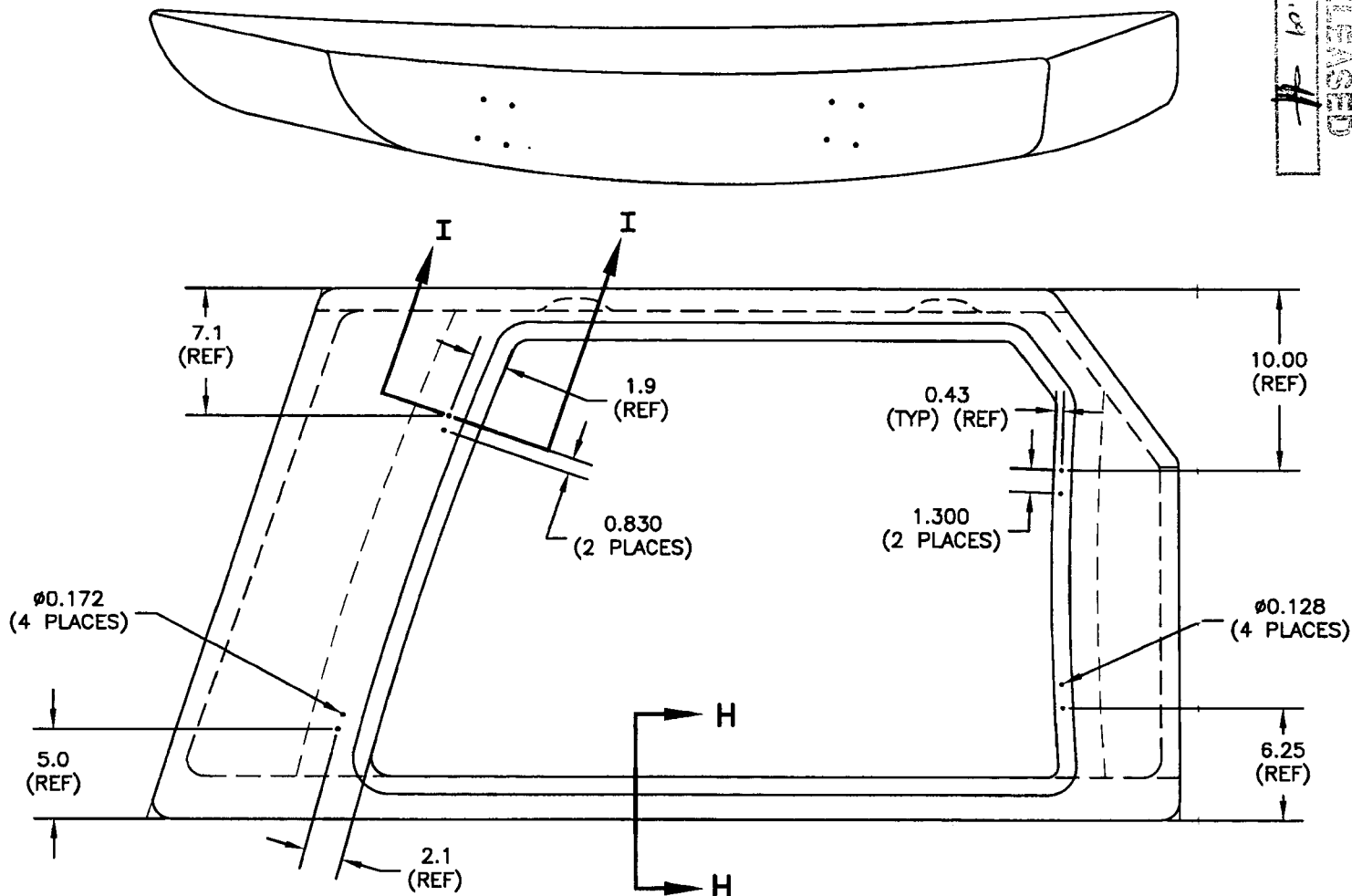
NOTE: Date & initial all entries



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07.04.02

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DATE	07.04.02	DRAWING NO.	D3188	REV. E
		TITLE	SPACEPOD BODY	SHEET 8 OF 11
		SCALE	NTS	

D3188-5 SPACEPOD BODY
(MAKE FROM D3188-1M)



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

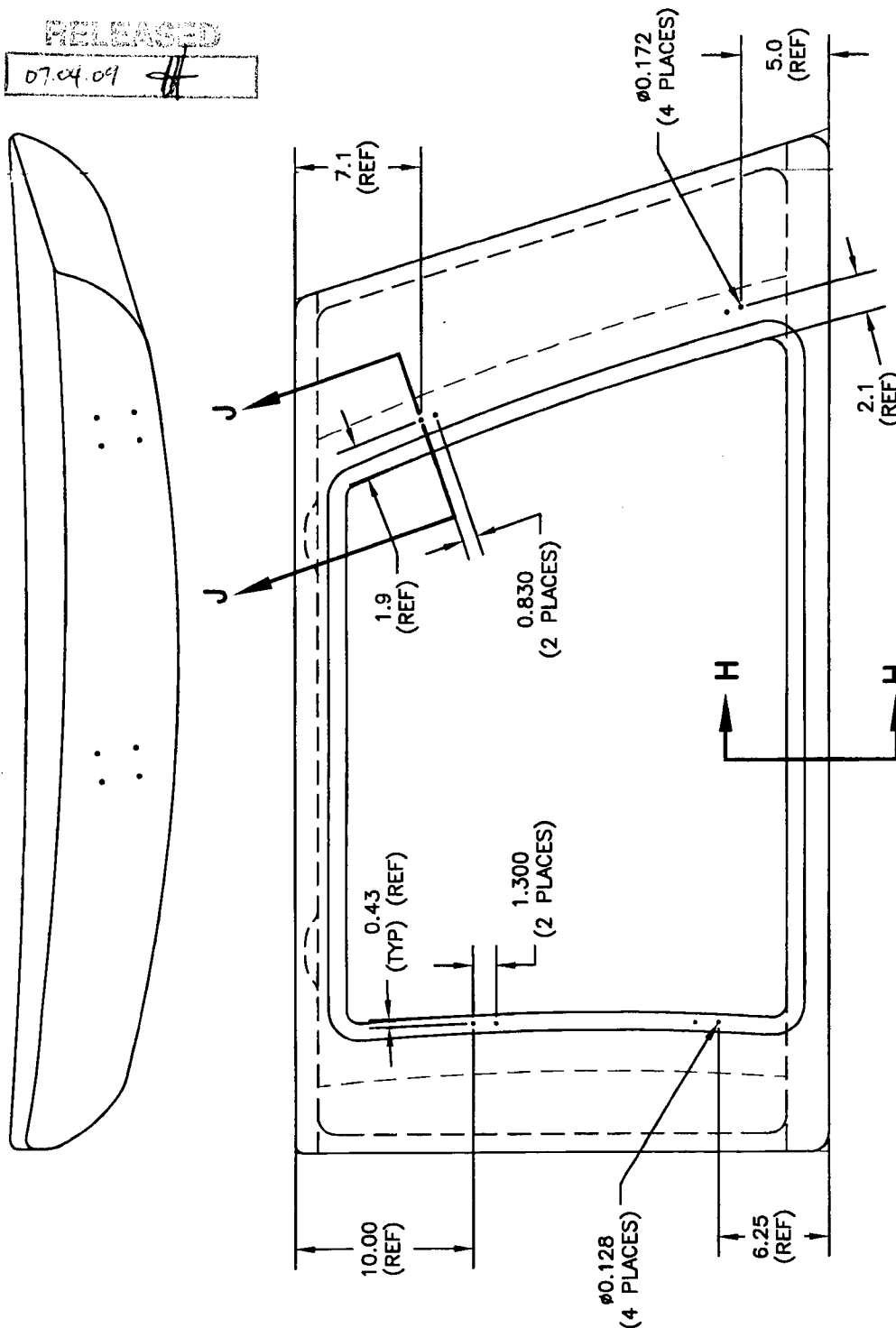
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DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN JB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS



- NOTES:
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
 - 2) SEE SHEET #11 FOR SECTION VIEWS

D3188-6 SPACEPOD BODY
(MAKE FROM D3188-2M)

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DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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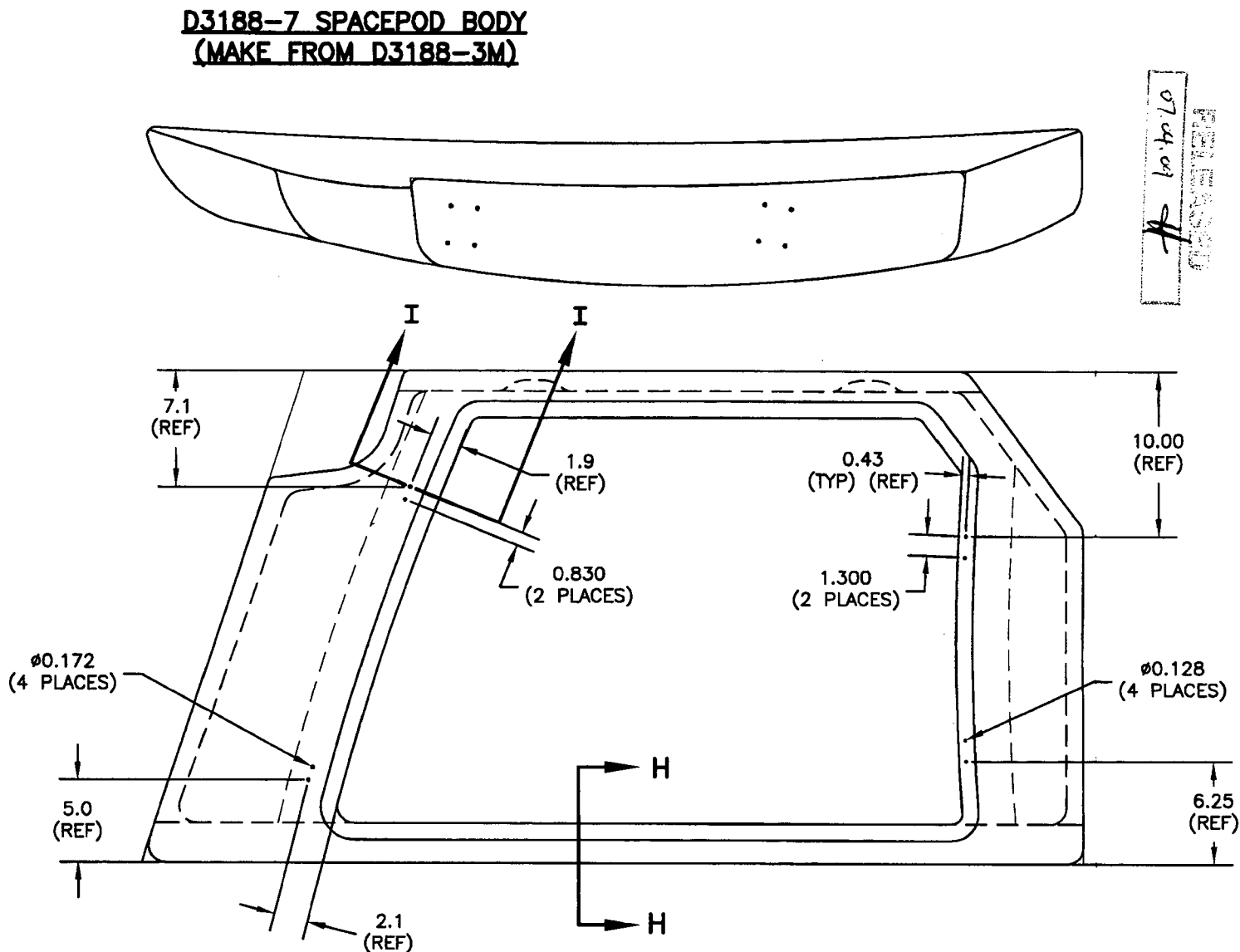
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			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries



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DATE 07.04.02	TITLE SPACEPOD BODY	REV. E SHEET 10 OF 11 SCALE NTS

RELEASED
07.04.02
#



NOTE:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries



DESIGN JB	DRAWN BY C.B.	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

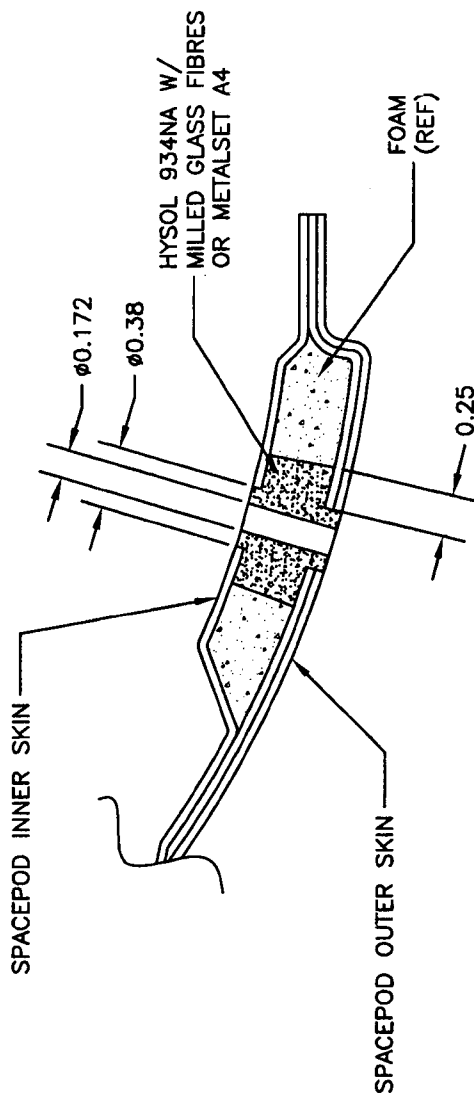
RELEASED
01.04.09 [Signature]

INSTALL AKS7-1032-130
INSERTS (29 PLACES)
PER D3188-1T1 (D3188-1/-3/-5/-7)
OR D3188-2T1 (D3188-2/-6)

FOAM
(REF)



SECTION H-H
(TYPICAL FLOOR SECTION)



SECTION I-I
(SECTION J-J OPPOSITE)
(4 PLACES PER POD)

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

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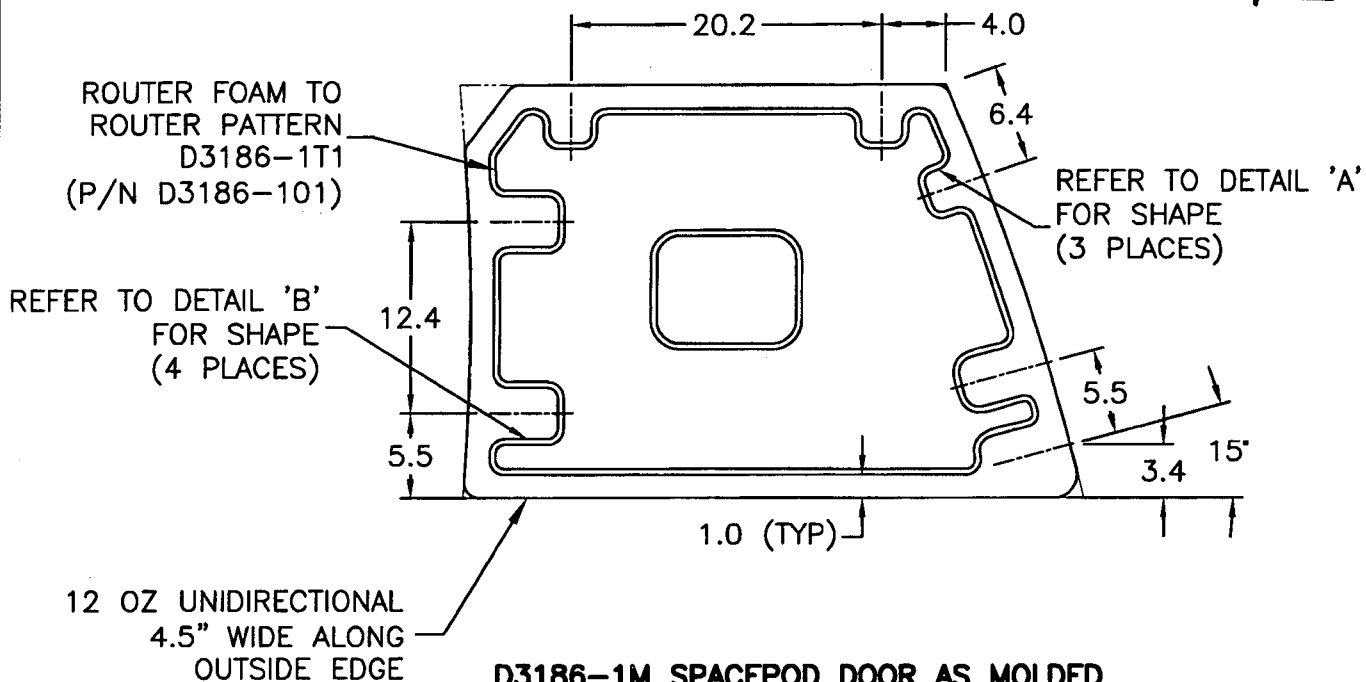
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CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 1 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED

07.02.27 H

**D3186-1M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries



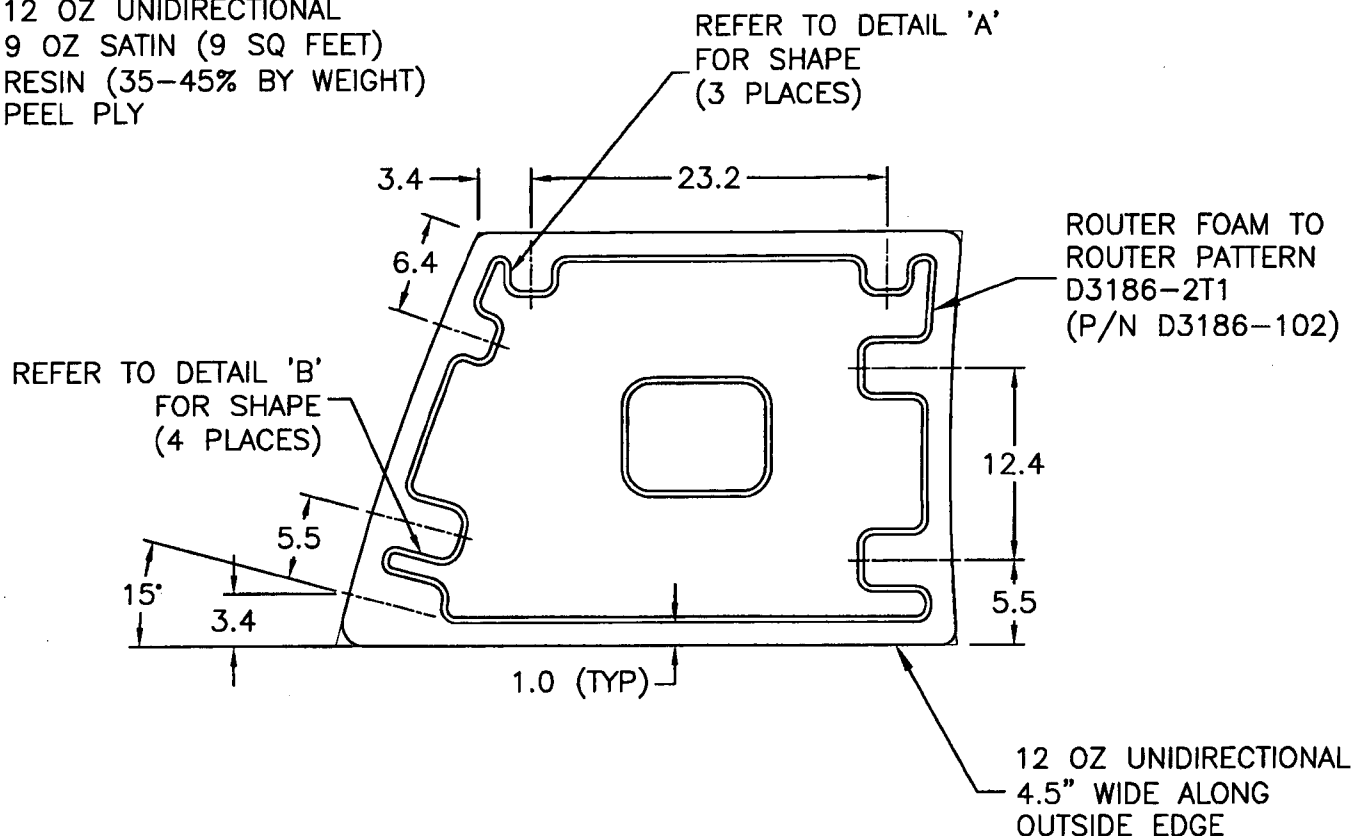
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CHECKED JB	APPROVED H	DRAWING NO. D3186	REV. D SHEET 2 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED

07.02.27



D3186-2M SPACEPOD DOOR AS MOLDED

NOTES:

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

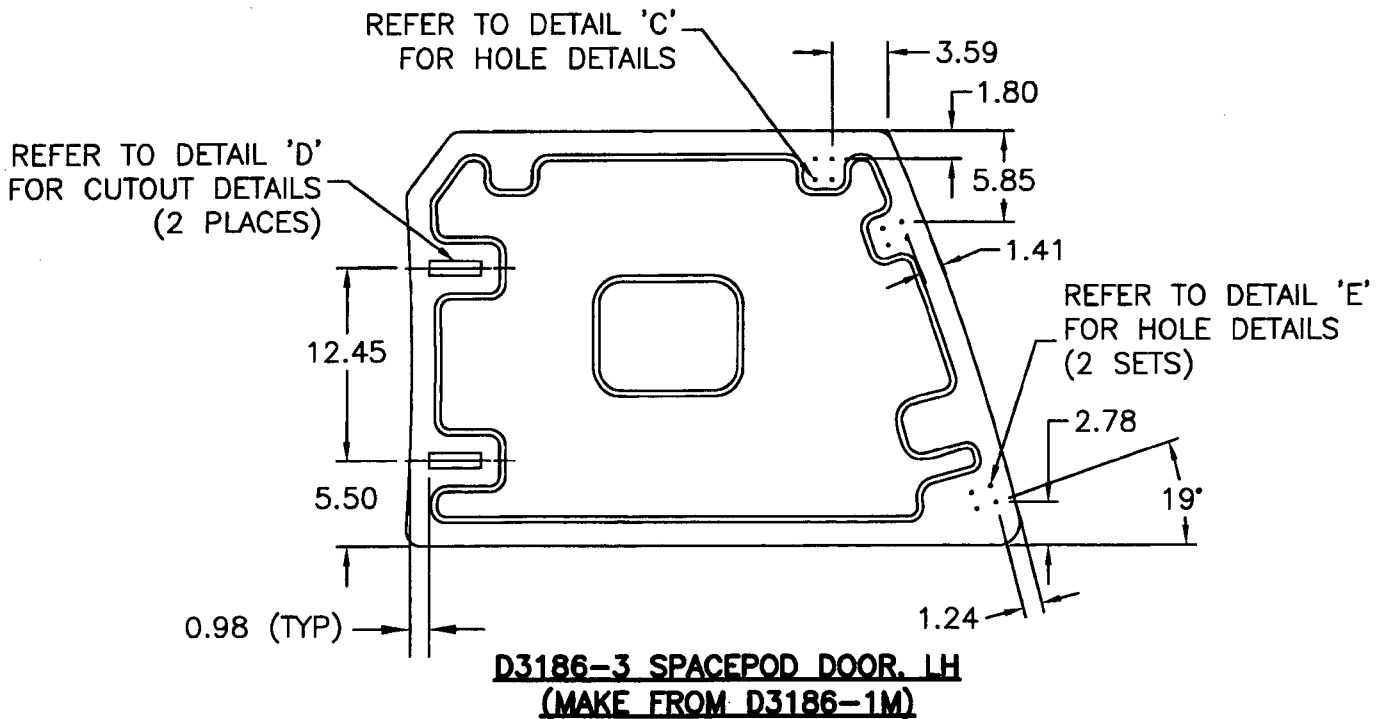
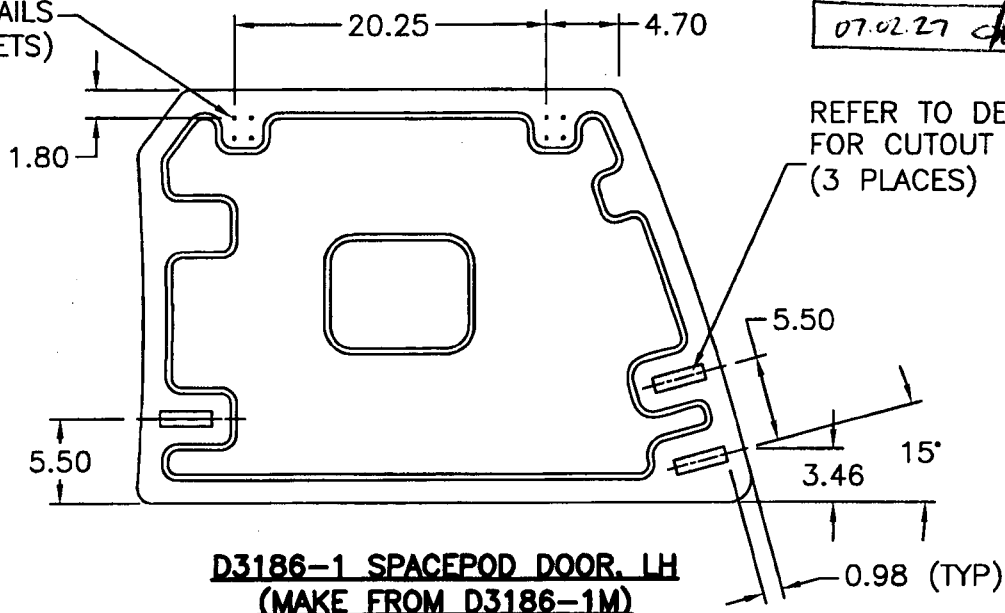
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DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 3 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

REFER TO DETAIL 'C'
FOR HOLE DETAILS
(2 SETS)

**NOTES:**

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

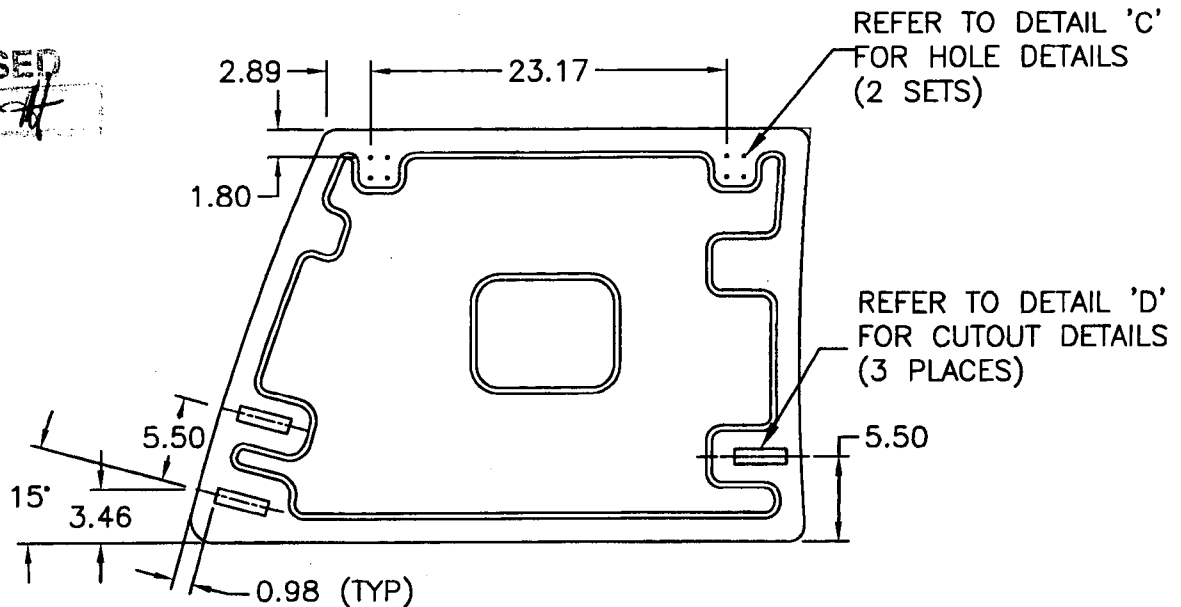
NOTE: Date & initial all entries

DART

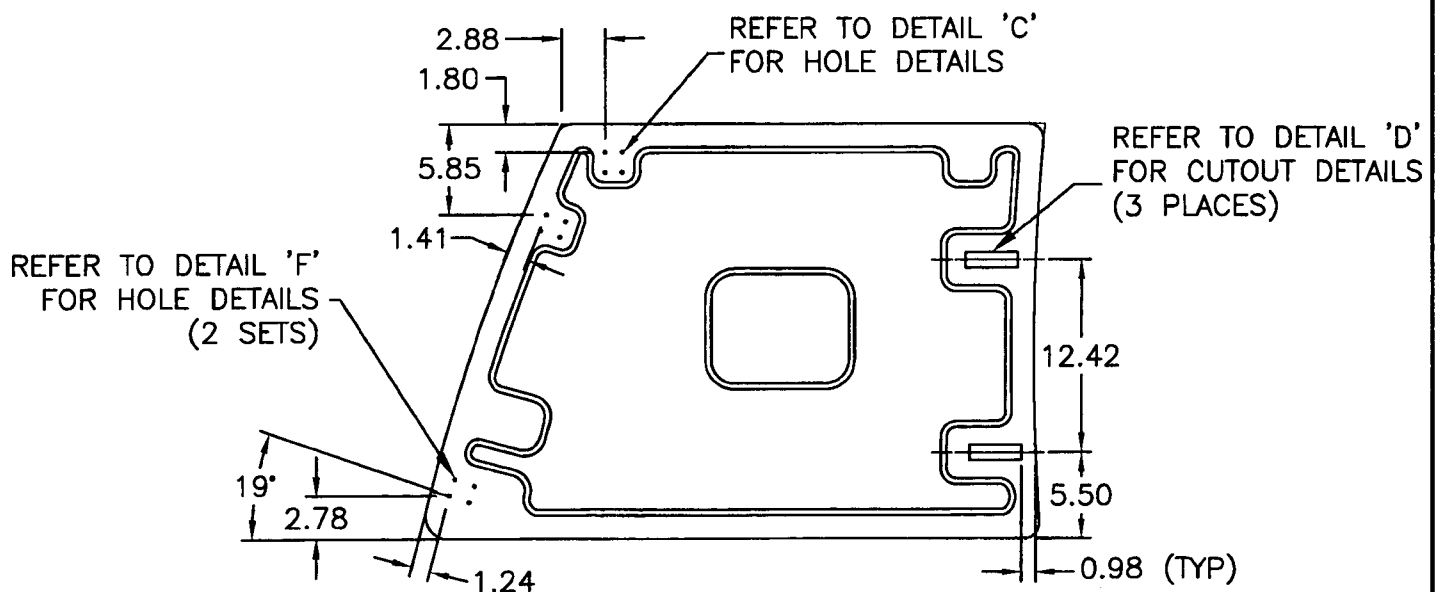
DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JB	APPROVED [Signature]	DRAWING NO. D3186	REV. D SHEET 4 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

RELEASED

07-02-27



D3186-2 SPACEPOD DOOR, RH
(MAKE FROM D3186-2M)



D3186-4 SPACEPOD DOOR, RH
(MAKE FROM D3186-2M)

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

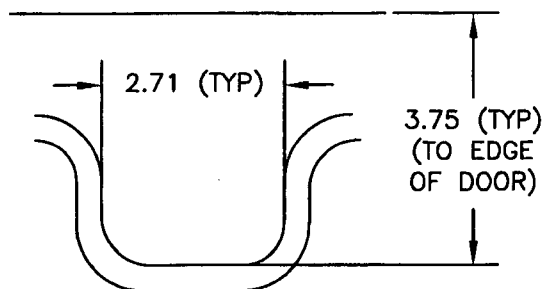
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

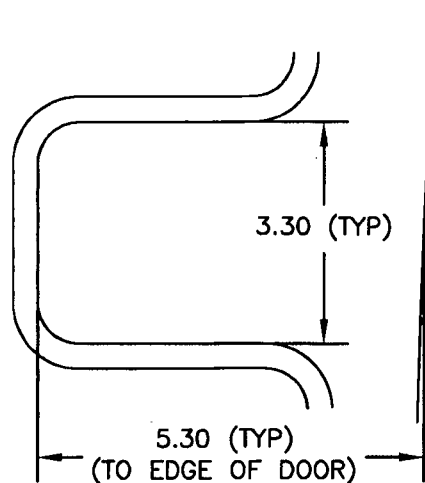
NOTE: Date & initial all entries



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CHECKED B	APPROVED [Signature]	DRAWING NO. D3186	REV. D SHEET 5 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS



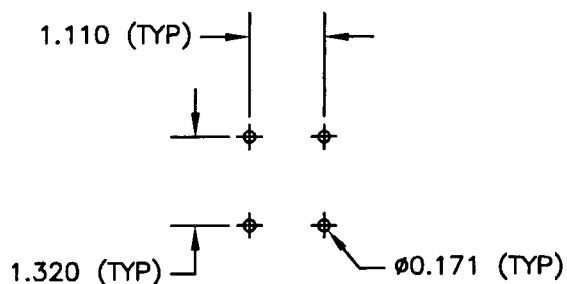
DETAIL A



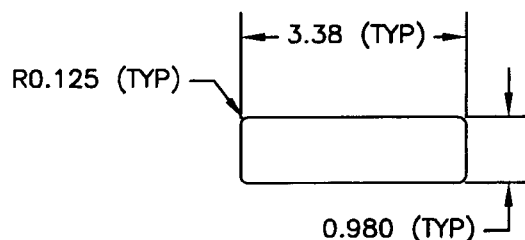
DETAIL B

RELEASED

07.02.27 [Signature]

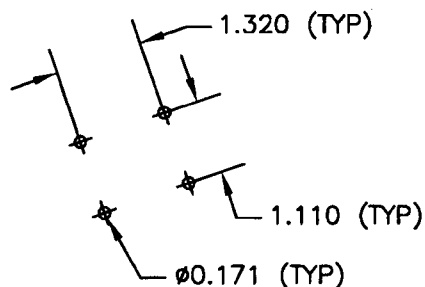


DETAIL C

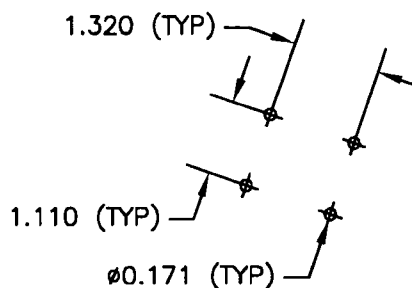


NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

DETAIL D



DETAIL E



DETAIL F

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries